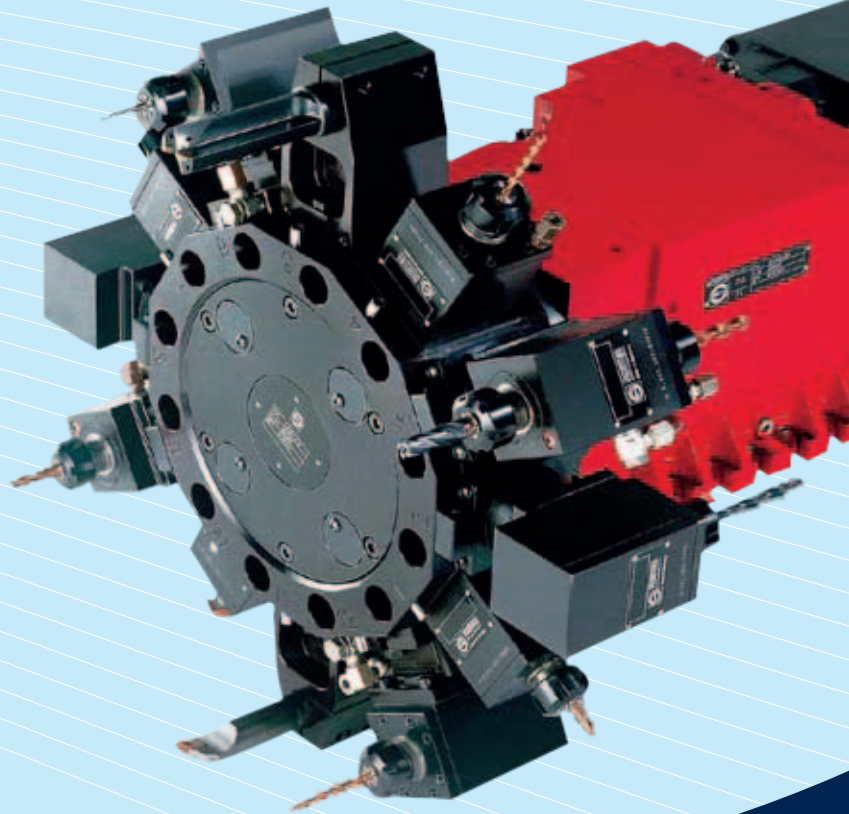
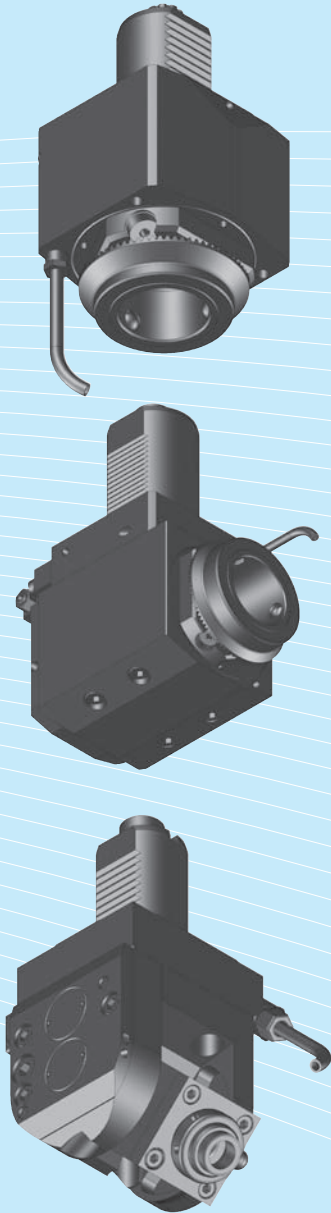


## Driven Toolholders for SAUTER Turrets



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## mimatic® Tool Systems for Sustainability and Efficiency

**BLUECOMPETENCE**

Alliance Member

Partner of the Engineering Industry  
Sustainability Initiative

Tools according to the policy of BLUECOMPETENCE are marked in this catalogue. More information on the program (Initiative) of the VDMA see pages 16-17 in the main catalogue.

## Selection According to Tool Type

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<b>Straight Unit</b> 		12, 20, 28, 36, 42, 52
<b>Angle Unit</b> 		13, 21, 29, 37, 43-44, 53-54
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<b>Angle Unit, adjustable 0-100°</b> 		15, 23, 31, 38, 48
<b>Saw Blade Holder</b> 		16, 24, 32, 49, 59

## Economical Complete Machining with Driven Toolholders

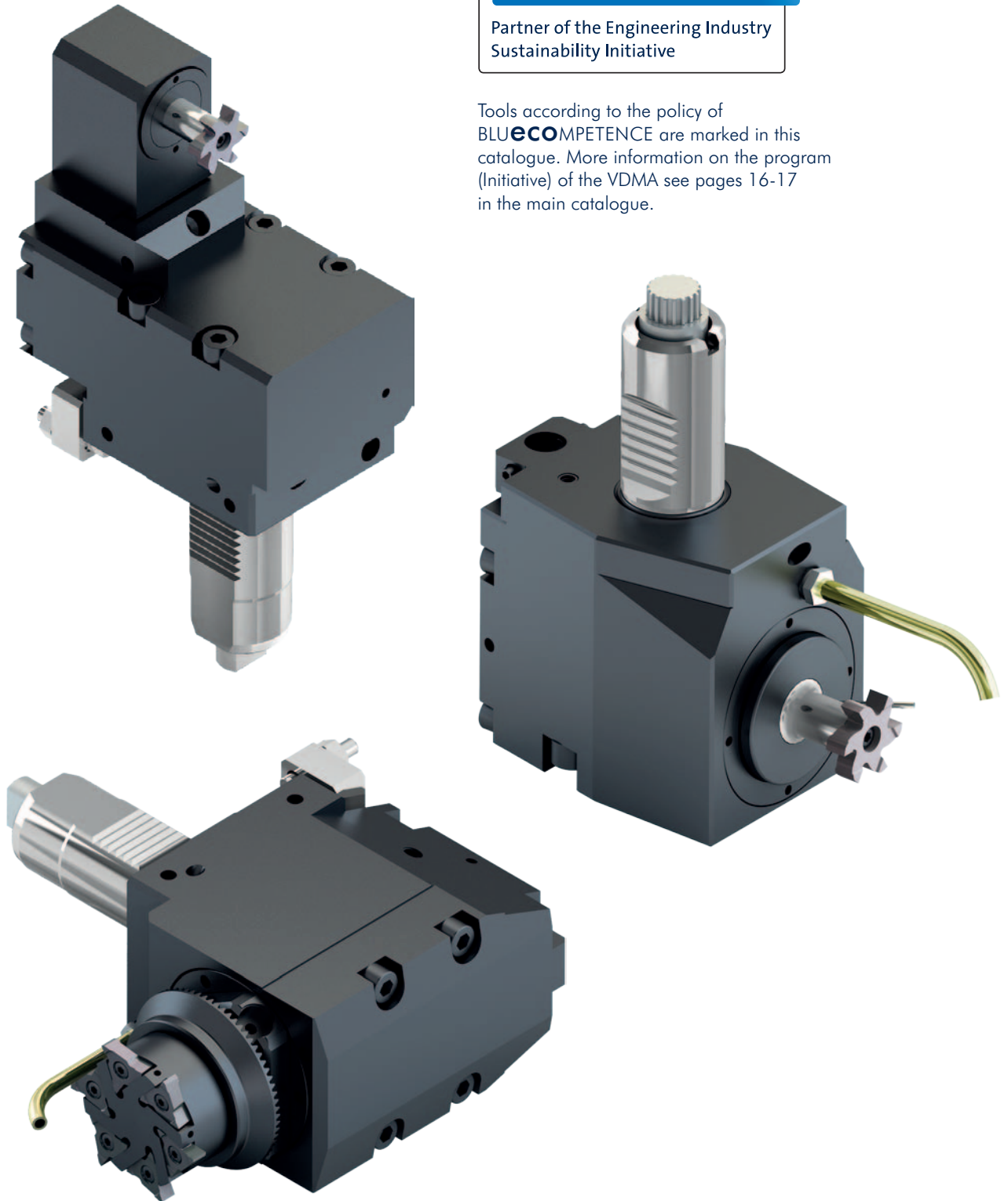
### mimatic<sup>®</sup> Tool Systems for Sustainability and Efficiency

**BLUeCOMPETENCE**

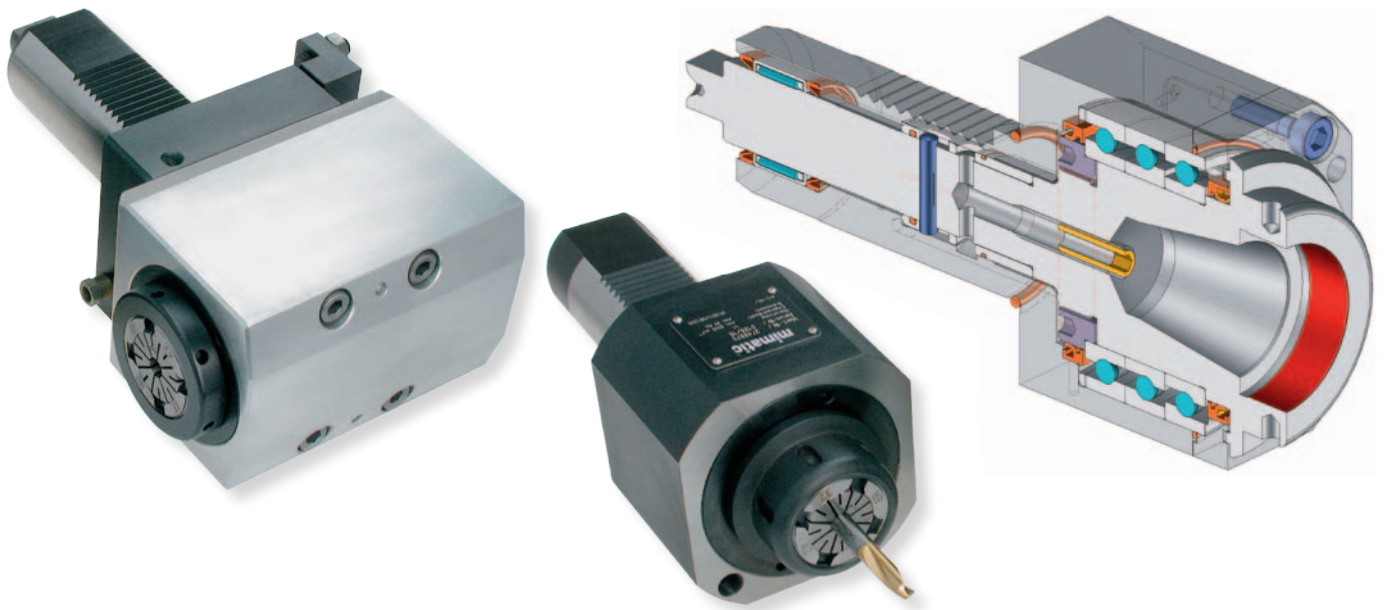
Alliance Member

Partner of the Engineering Industry  
Sustainability Initiative

Tools according to the policy of  
BLUeCOMPETENCE are marked in this  
catalogue. More information on the program  
(Initiative) of the VDMA see pages 16-17  
in the main catalogue.







As a medium-size company with global activities, we are developing and producing CNC precision standard and special tools for the automotive, mechanical engineering, aircraft and woodworking industries since 1974.

The mimatic® brand is acknowledged worldwide for its compliance with strict quality requirements in the context of integrated system solutions for the machining segment.

The philosophy of the Company is based upon synergy between highly motivated staff and excellent standards in the areas of technology and quality development. These attributes enable us to provide the perfect solution to every specific customer requirement.

**Products from mimatic®**

- Driven toolholders for CNC lathes and machining centers
- Cutting tools
- Clamping systems

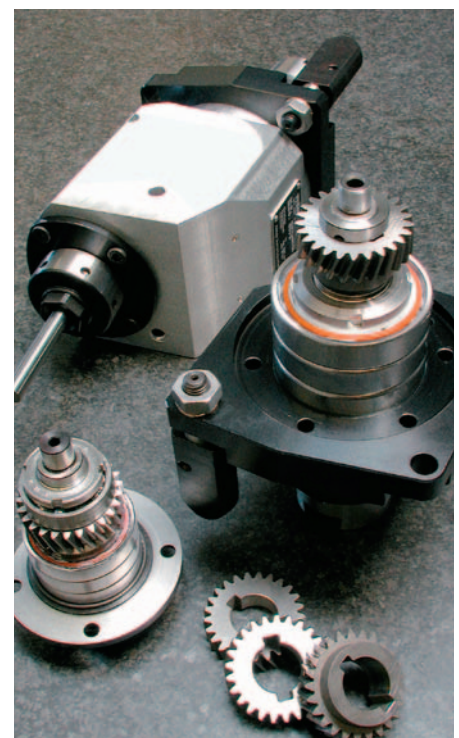
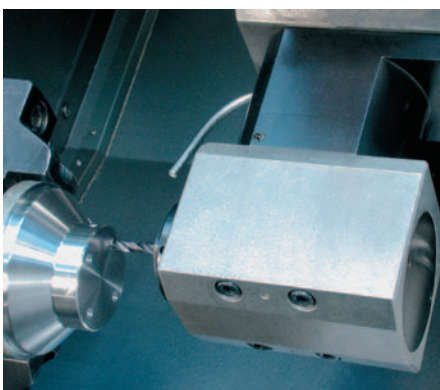
Our quality systems have been approved since 1998 and we are certified to DIN EN ISO 9001:2000.

The know-how of our 140 employees worldwide is available to you at any time on location.

Many years ago we started to specialize in the production of driven toolholder units for metal processing. These are installed on CNC lathes.

Our products are used for large volume manufacturing and facilitate complete processing without multiple clamping of complex workpieces.

Our products contribute towards constant improvements in our customers production processes due to the use of the most modern technology allied to the highest levels of quality.



## Versions

Our boring and milling units are suitable for most of the popular turning machines and lathe equipment manufacturers. We produce the following types:

- Straight and offset units
- Internal and/or external coolant supply
- Gear multiplication or reduction
- Single or multi-spindle versions
- Angle heads for the production of angled holes, by means of adjustable and fixed angles
- Sawblade holders for sawing or slotting of workpieces
- Every popular type of tool system can be supplied

Technology and quality is at the forefront of our business:

- Highly precise bearing technology (high quality spindle and taper roller bearings)
- Specially optimized gears guarantee an excellently smooth run
- High torque transmission, rigidity and RPM`s
- Highest concentricity and facing accuracy  $< 3 \mu\text{m}$
- Internal coolant supply up to 70 bar
- Use of high pressure seals und friction optimized special seals
- Additional labyrinth seals protect the bearings from the penetration of dirt and coolant

- Internal clamping nut guarantees a compact tool length and optimum bearing positioning ensures maximum axial and radial support at the spindle and high stability
- Alignment pins/blocks on angle units for minimum setup time and fine centreline adjustment
- Limited dry usage of driven toolholders with internal coolant through the spindle (i.C.). Running in dry condition should be avoided. Tools should frequently run with coolant. Easily changeable from internal or external coolant supply.
- The coolant filtering capabilities of the machine should be  $40 \mu\text{m}$  or less.

## Modular Quick Change System „mimatic mi“

### Advantages

- Universal tool clamping system for all production areas
- Presetting of the tools off-line by length adjustment screw
- Tool change within seconds
- Concentricity of the interface  $< 0,002 \text{ mm}$
- Secure holding force by form-locking
- Very short design
- Toolholders in different sizes
- All toolholders with internal coolant

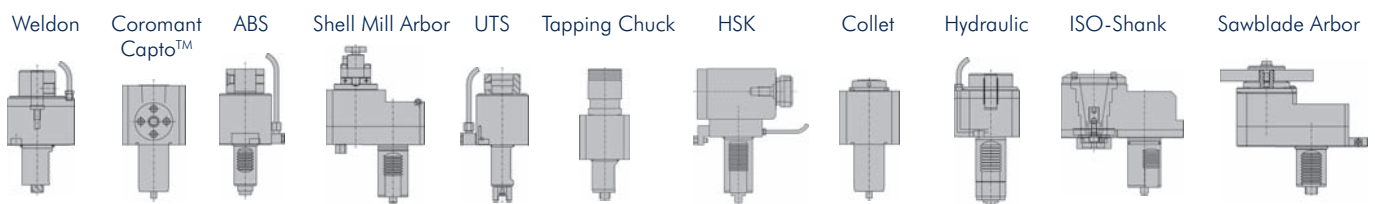
### Modular Toolholders in different Sizes for all Production Areas

- Tapping toolholders
- Collet toolholders (internal and external nut)
- Hydro-Flex hydraulic toolholders
- Thread tightening toolholder cutters
- Morse taper shank toolholders
- Weldon and Whistle Notch toolholders
- Shell mill toolholders

All toolholders are available for use with your presetter.

**Find more information of „mimatic mi“ on pages 60-71.**

## Tool System Examples



## Performance Values

The torques  $M_{max}$  specified in the tables below refer to shock-free processing (e.g. threaded cutting). For processes involving major shock loads (e.g. milling or multi-edge knocking), a value reduction of up to 50 % and more needs to be taken into account. The values  $n_{max}$  and  $P_{max}$  rendered are guideline values for short-time operation.

The permissible relative operating duration depends

- on the version of the spindle unit (with or without gear)
- on the presence of a cooling system and the type of cooling (external or internal through the tool spindle)
- on the processing torque

At a charge of about 60 % of the maximum values the working life calculated amounts to approx. 2.000 hours. Spindle units with gears produce more noise at higher speeds!

### Operating Instructions

**Initial Start-up:** To ensure long tool life it is important to properly “run-in” the tools. This procedure serves to reduce the internal friction in the driven unit and to evenly distribute the grease in the precision bearings.

- **Max. RPM in the first operation hour should not exceed 70 % of the maximum permissible RPM.**
- **Never run the tool above the maximum permissible torque rate and/or maximum permissible RPM (see also the drawing of the unit).**

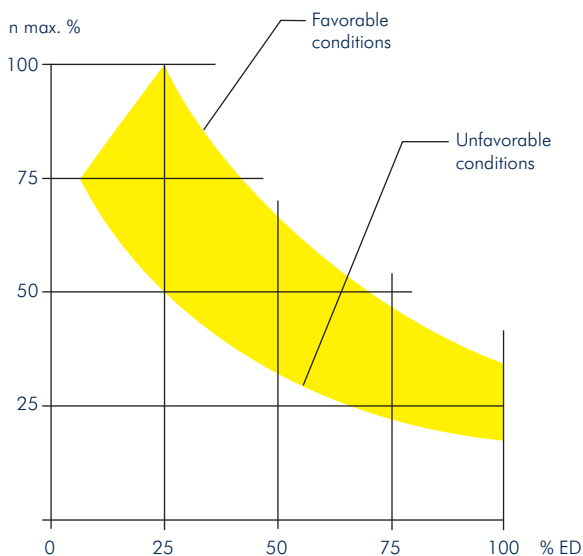
**Tools with internal coolant through the spindle (i.C.):** To avoid premature wear and damage to the seal system we recommend to filter the coolant to 40  $\mu\text{m}$  minimum.

Filter grades of 40  $\mu\text{m}$  worked in operation with very good results. The maximum permissible coolant pressure can be taken from the technical data of the driven toolholder.

Driven Toolholders with internal coolant through the spindle (i.C.) should **never run without coolant**. The coolant should flow through the tool, before the tool drive is switched on. Running in dry condition damages the internal seals.

**Service interval:** The tool life of the driven toolholder depends strongly on the application. Wear parts such as bearings and seals should be exchanged. We recommend to send the tools at least once annually to our service center for cleaning and regreasing. Tools with internal coolant through the spindle should be serviced every 6 months.

### Optimum Relative Cycle Times (Guideline Values)

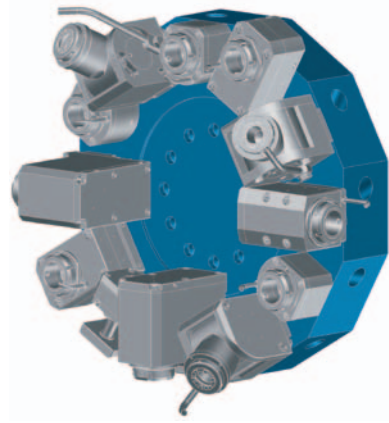


### Determination of the maximum permissible cycle times per minute $ED_{max}$

The maximum permissible cycle times per minute may not be under any circumstances exceeded.

CT max: maximum permissible cycle times in percent per minute (%/min.)

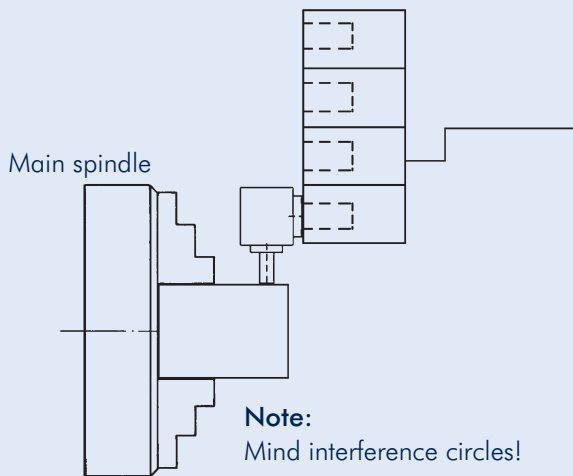
## Operation with Disc-type Turrets



**Tools are fixed on the the revolver face!**

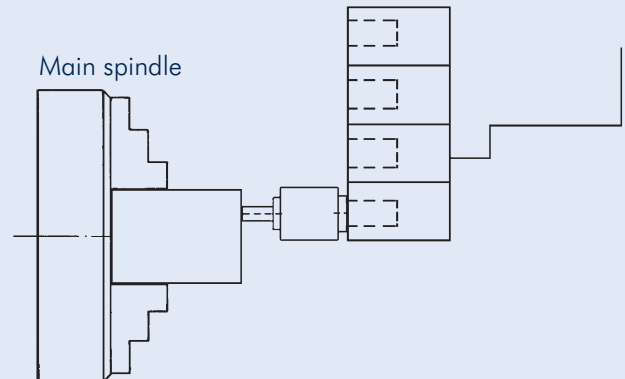
### Radial Operation

Radial tool holders with 90° angle

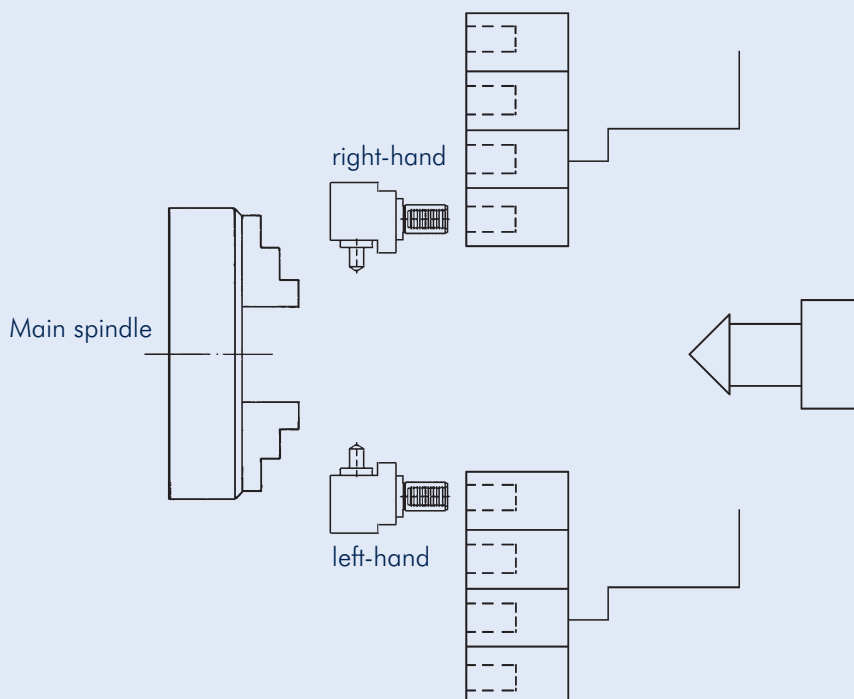


### Axial Operation

Axial tool holders straight version

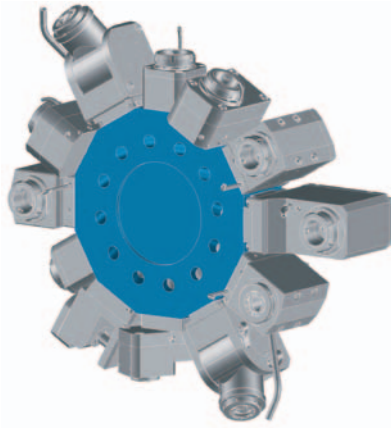


### Right- and Left-hand Versions of the Driven Toolholders





## Operation with Star-type Turrets

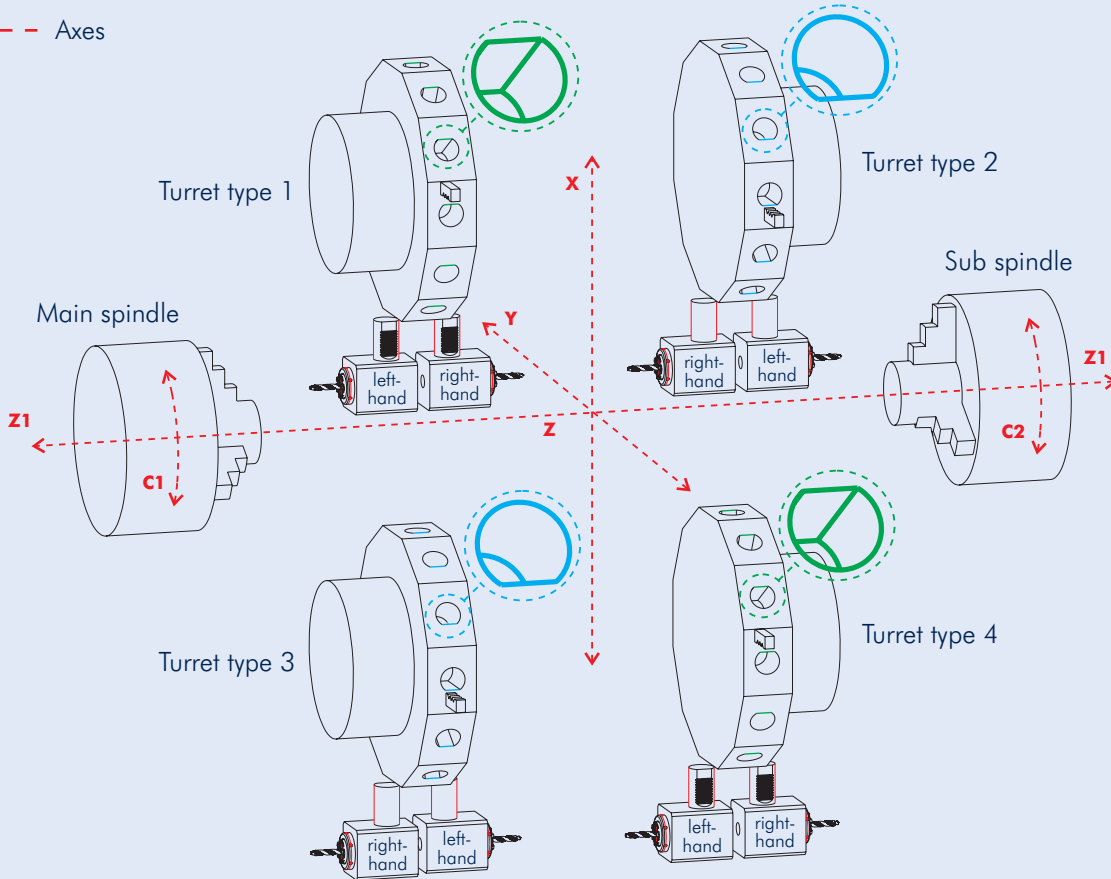


### Tools are fixed on the the revolver circuit!

The orientation of the revolver to the spindle is important. Machines with Star-type Turrets often come with a sub spindle.

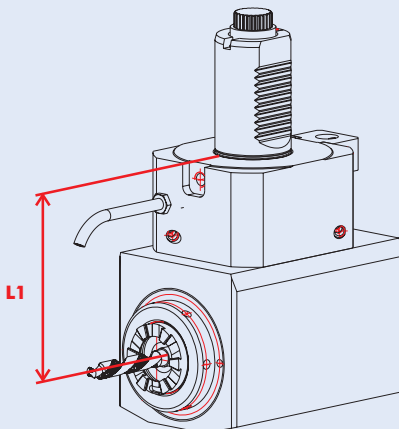
## Right- and Left-hand Versions on Star-type Turrets with Main- and Sub-Spindle

--- Axes



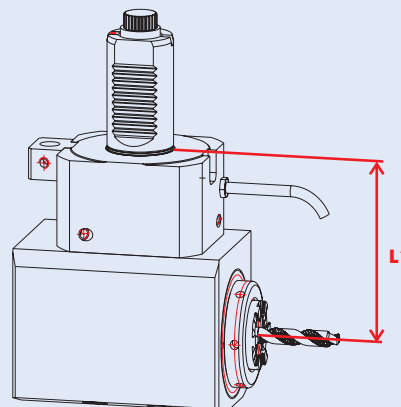
### Left-hand Version

Please note dimension L1



### Right-hand Version

Please note dimension L1



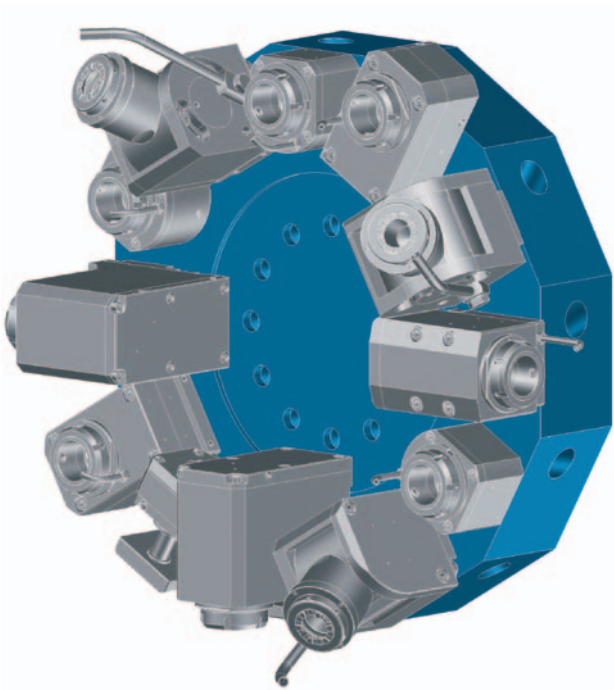
**Please check interference circles with fixed tools!**

**Data**

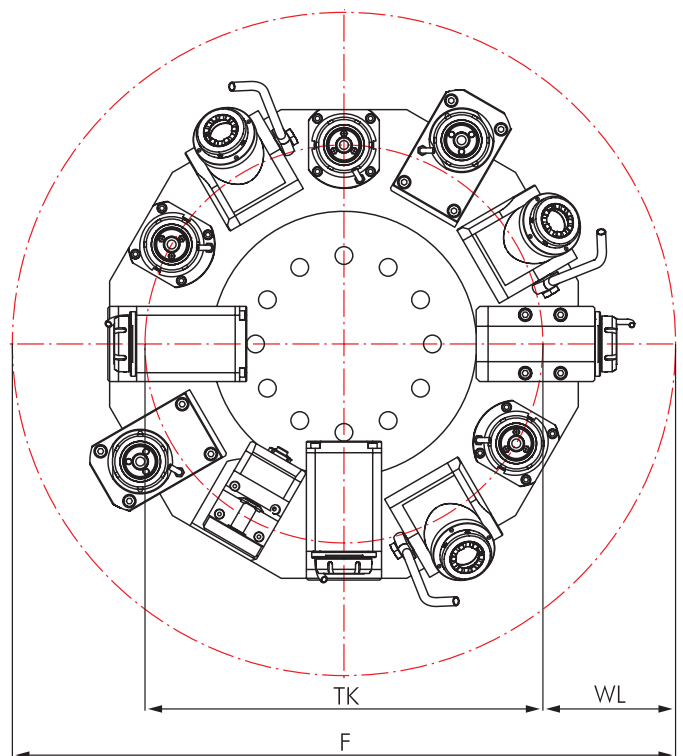
Disc-type Turret	Turret Stations
<b>Drive</b>	<b>DIN 5482 (B 15 x 12)</b>



**Disc-type Turret VDI 30**



**Interference Circles**



The interference circles are depending on your CNC machine. You can find it in your machine instruction manuals.

## Driven Toolholders

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<b>Angle Unit</b>	13		
<b>Angle Unit, Offset Type</b>			14
<b>Angle Unit, adjustable 0-100°</b>			15
<b>Saw Blade Holder</b>			16

## Options and Accessories

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<b>Accessories</b>		Collets DIN 6499 Threading Collets Wrenches Clamping Nuts Sleeves and Bushings	87 87 87 87 89



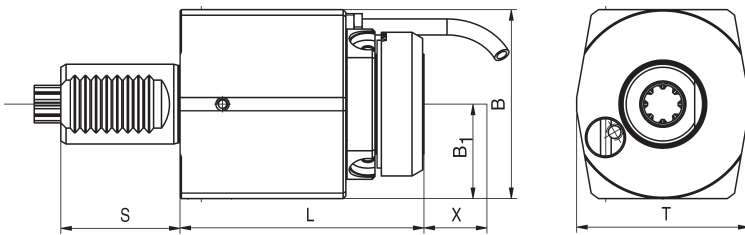
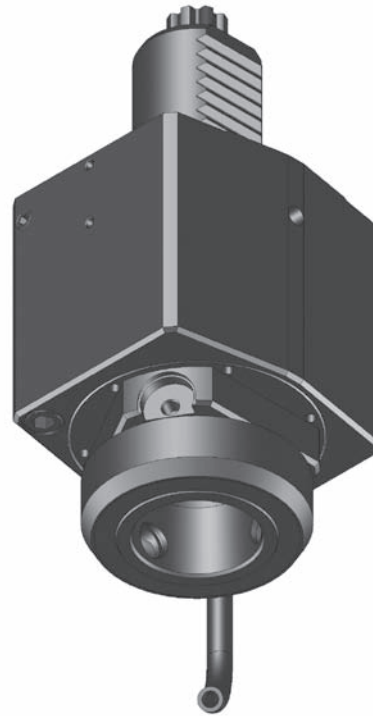
### Delivery information

Driven toolholders with mi quick-change interface are supplied with operating wrench (see spare parts on page 69).  
Driven toolholders with other interfaces are supplied without clamping wrench (see accessories on page 87).

# Straight Unit

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer	
<b>SAUTER</b>	
with Drive	
<b>DIN 5482 (B 15 x 12)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 30
Drive	DIN 5482 B 15 x 12 Z = 8 Ø 14,5 mm
Modular Interfaces	
<b>mimaticMi</b>	

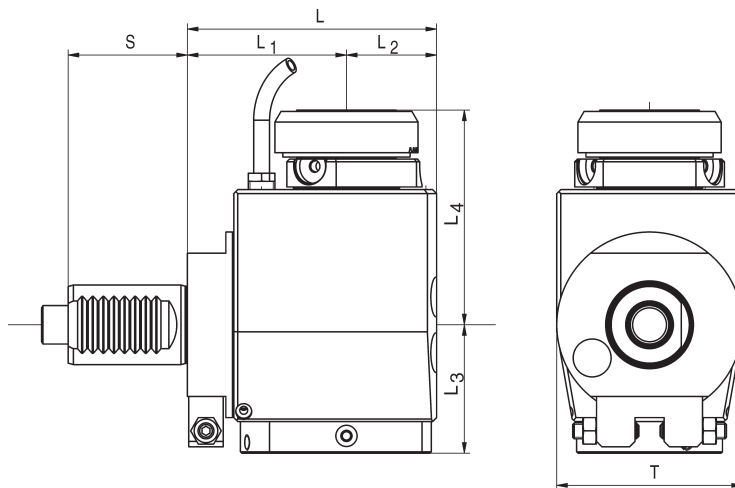
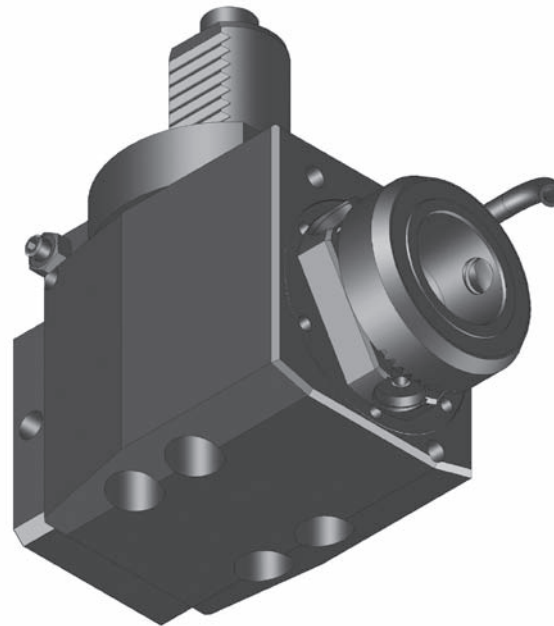


Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	B mm	B1 mm	S mm	T mm	Rotating direction
123780	ER 25	0,5-16	40 Nm	6.500 / 6.500	i = 1:1	external	77	70	35,0	45	70	↺ ↻
124135	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	77	70	35,0	45	70	↺ ↻
124137	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	92	71	35,5	45	65	↺ ↻

# Angle Unit

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer	
with Drive	
<b>DIN 5482 (B 15 x 12)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 30
Drive	DIN 5482 B 15 x 12 Z = 8 Ø 14,5 mm
Modular Interfaces	



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124491	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	94	60	34	36,5	60	45	70	
101413	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	94	60	34	54,0	60	45	70	
169181	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	94	60	34	48,5	81	45	70	

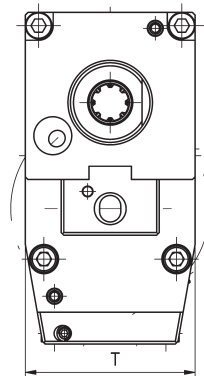
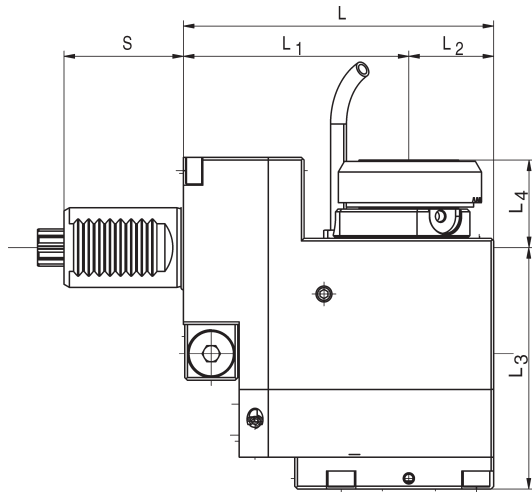
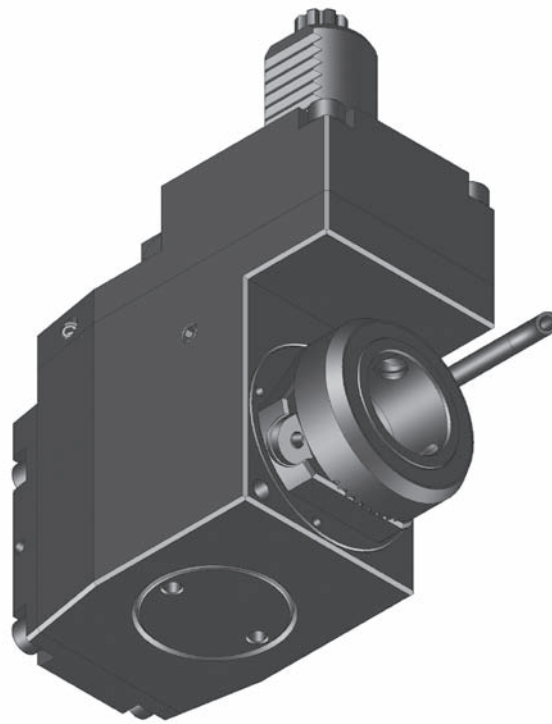
\* With clamping nuts with sealing, seals see page 88



# Angle Unit, Offset Type

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

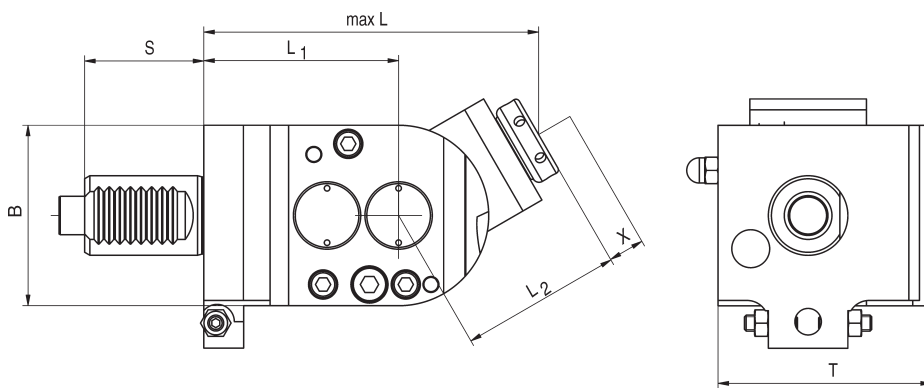
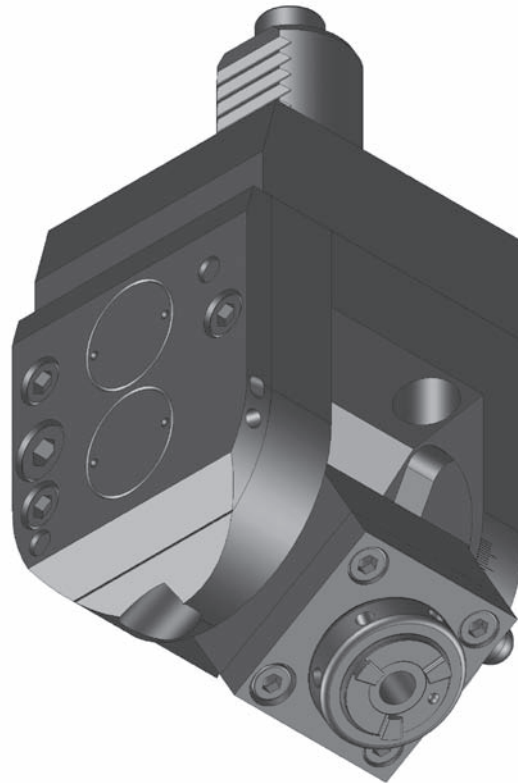
for Turret Manufacturer	
<b>SAUTER</b>	
with Drive	
<b>DIN 5482 (B 15 x 12)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 30
Drive	DIN 5482 B 15 x 12 Z = 8 Ø 14,5 mm
Modular Interfaces	
<b>mimaticMi</b>	



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124497	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	117	85	32	91	15	45	64	↺ ↻
166412	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	117	85	32	91	15	45	64	↻ ↺
124401	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	117	85	32	91	33	45	64	↻ ↺

# Angle Unit, Adjustable 0-100°

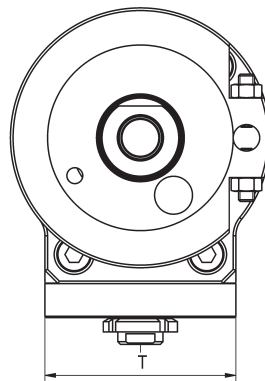
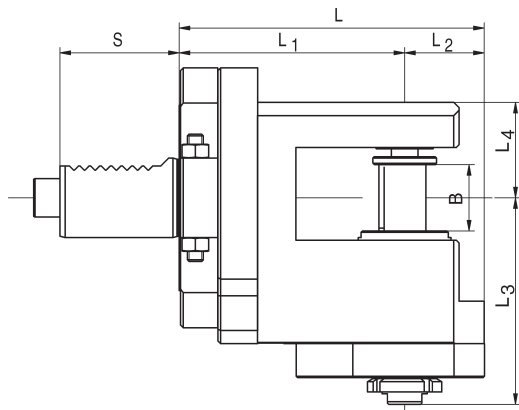
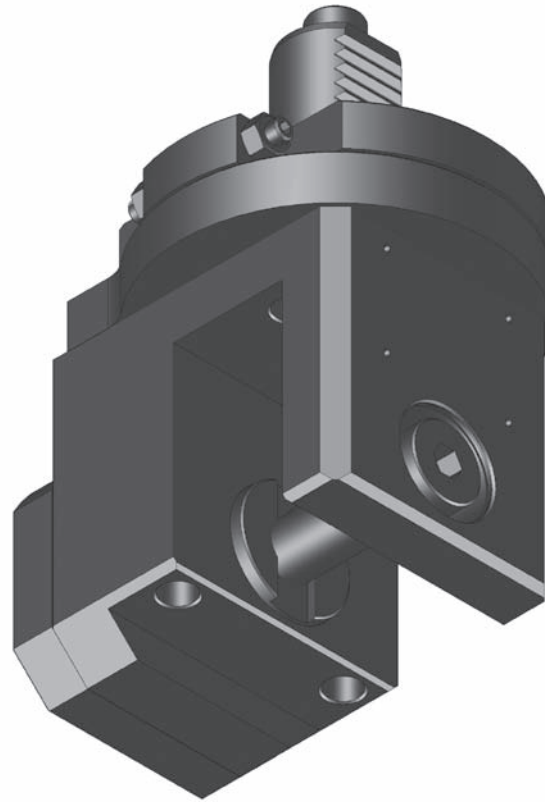
for Turret Manufacturer	
with Drive	
<b>DIN 5482 (B 15 x 12)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 30
Drive	DIN 5482 B 15 x 12 Z = 8 Ø 14,5 mm



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	B mm	S mm	T mm	Rotating direction
101705	ER 16	0,5-10	6 Nm	6.500 / 6.500	i = 1:1	external	138	73,5	64,5	85,5	45	68	

# Saw Blade Holder

for Turret Manufacturer	
with Drive	
<b>DIN 5482 (B 15 x 12)</b>	
Dimensions	
Turret type	Disc-type Turret
Shank	VDI 30
Drive	DIN 5482 B 15 x 12 Z = 8 Ø 14,5 mm



Order No.	Fitting dia. mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	B mm	S mm	T mm
101777*	16	20 Nm	6.500 / 2.450	i = 2,66:1	external	115	85	30	77,3	36	25	45	72



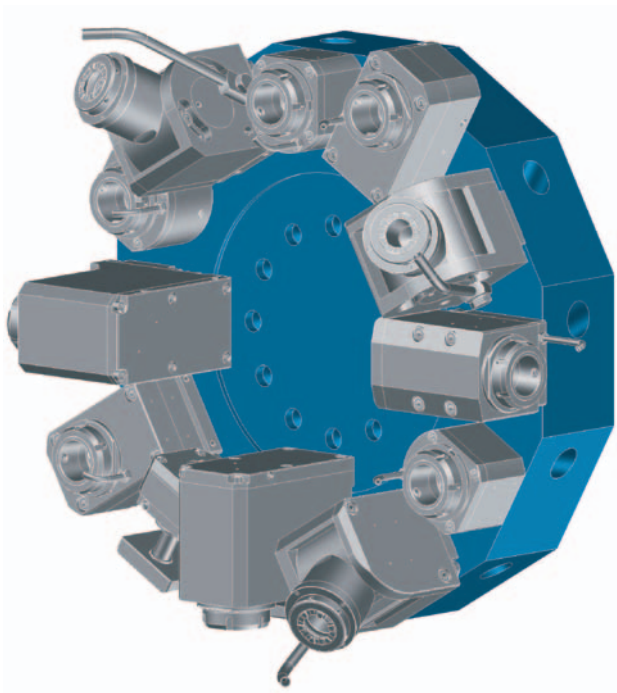
Picture shows angle driven toolholder (90°) for a Sauter VDI 40 turret with a mimatic<sup>®</sup> mi50 interface. The mimatic<sup>®</sup> mi interface is a very innovative modular quick change system to reduce machine downtimes because all units can be preset outside the machine.

**Data**

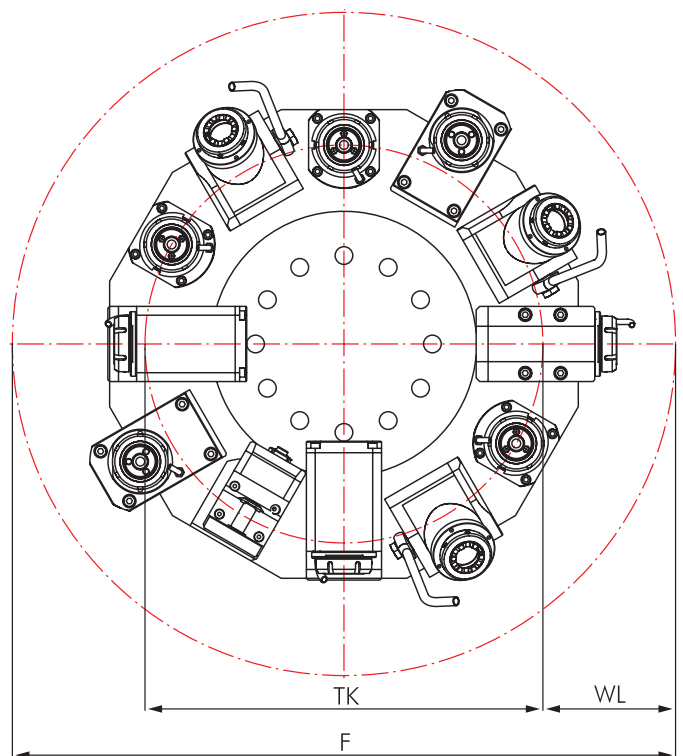
Disc-type Turret	Turret Stations
<b>Drive</b>	<b>DIN 5482 (B 17 x 14)</b>



**Disc-type Turret VDI 40**



**Interference Circles**



The interference circles are depending on your CNC machine. You can find it in your machine instruction manuals.



## Driven Toolholders

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<b>Angle Unit, Offset Type</b>			22
<b>Angle Unit, adjustable 0-100°</b>			23
<b>Saw Blade Holder</b>			24

## Options and Accessories

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<b>Standard VDI Toolholders</b>		VDI Toolholders Accessories	80-86 87-89
<b>Accessories</b>		Collets DIN 6499 Threading Collets Wrenches Clamping Nuts Sleeves and Bushings	87 87 87 87 89



### Delivery information

Driven toolholders with mi quick-change interface are supplied with operating wrench (see spare parts on page 69).  
Driven toolholders with other interfaces are supplied without clamping wrench (see accessories on page 87).

# Straight Unit

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

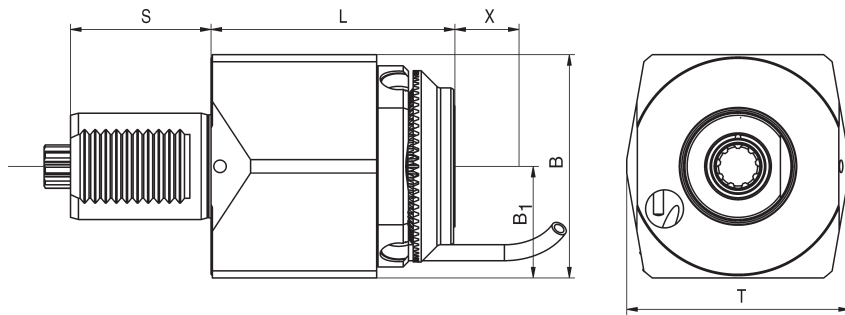
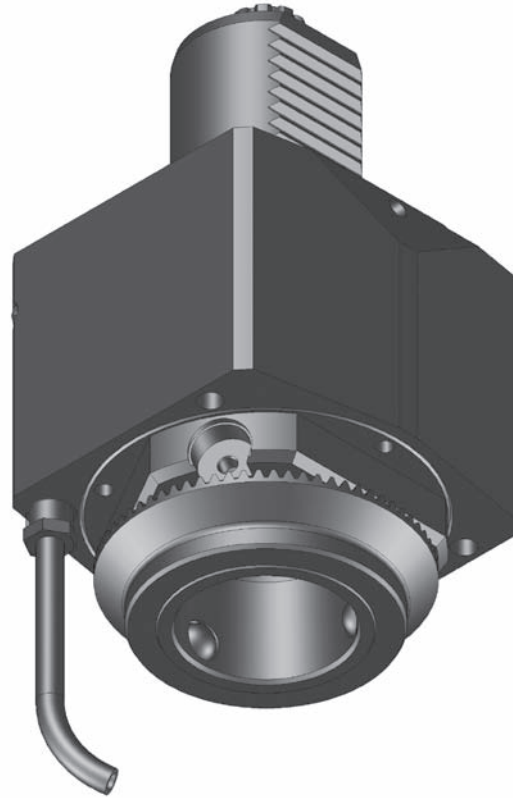
**DIN 5482 (B 17 x 14)**

Dimensions

Revolver type	Disc-type Turret
Shank	VDI 40
Drive	DIN 5482 B 17 x 14 Z = 9 Ø 16,5 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	B mm	B1 mm	S mm	T mm	Rotating direction
123797	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	95	80	40	53	80	↺ ↻
124154	ER 32*	1,0-20	80 Nm	6.000 / 6.000	i = 1:1	internal	80	89	40	53	80	↺ ↻
124157	mi 50	0,5-20	80 Nm	6.000 / 6.000	i = 1:1	internal	92	89	40	53	80	↺ ↻
124146	Hydro-Flex 20	6,0-20	80 Nm	8.000 / 8.000	i = 1:1	internal	83	89	40	53	80	↺ ↻

# Angle Unit

Connectible in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

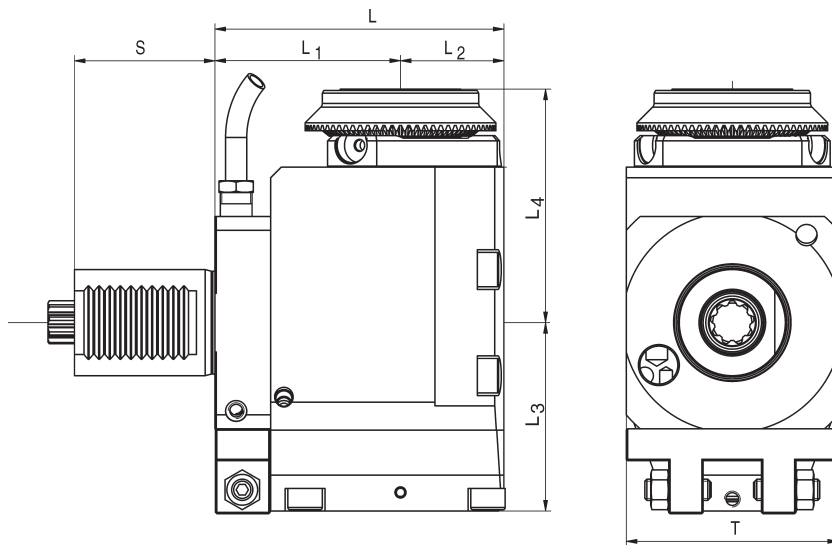
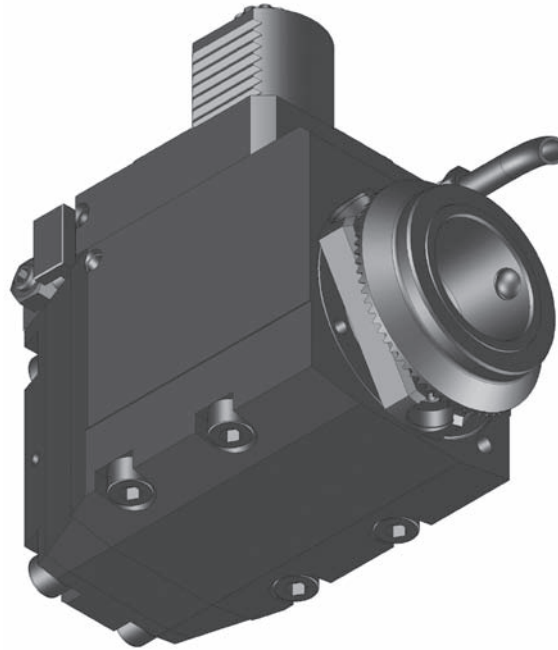
**DIN 5482 (B 17 x 14)**

Dimensions

Revolver type	Disc-type Turret
Shank	VDI 40
Drive	DIN 5482 B 17 x 14 Z = 9 Ø 16,5 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124516	ER 32	1,0-20	50 Nm	5.400 / 5.400	i = 1:1	external	113	70	43	69,0	70	53	80	↺ ↻
124804	ER 32*	1,0-20	50 Nm	5.200 / 5.200	i = 1:1	internal	113	70	43	75,5	70	53	80	↺ ↻
124805	mi 50	-	50 Nm	6.500 / 6.500	i = 1:1	internal	113	70	43	75,5	88	53	80	↺ ↻
124801	Hydro-Flex 20	6,0-20	50 Nm	5.200 / 5.200	i = 1:1	internal	113	70	43	75,5	82	53	80	↺ ↻
124909	ER 25*	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	109	70	39	72,5	75	53	85	↺ ↻
124683	mi 40	-	20 Nm	6.000 / 12.000	i = 1:2	external	109	70	39	72,5	95	53	85	↺ ↻

\* With clamping nuts with sealing, seals see page 88

# Angle Unit, Offset Type

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

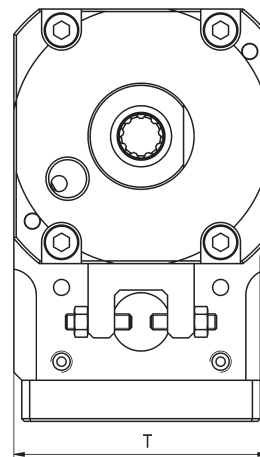
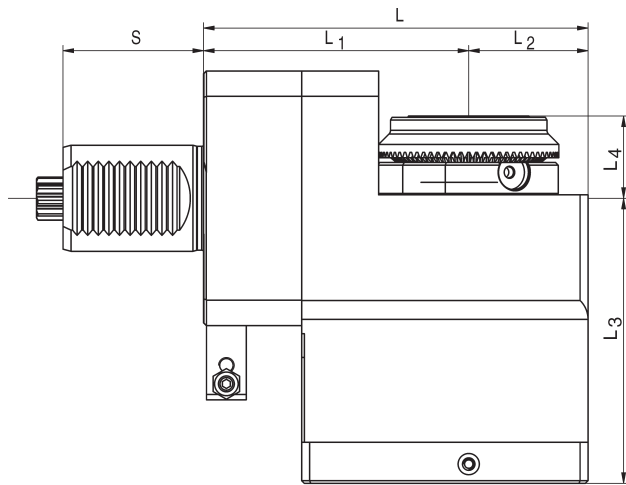
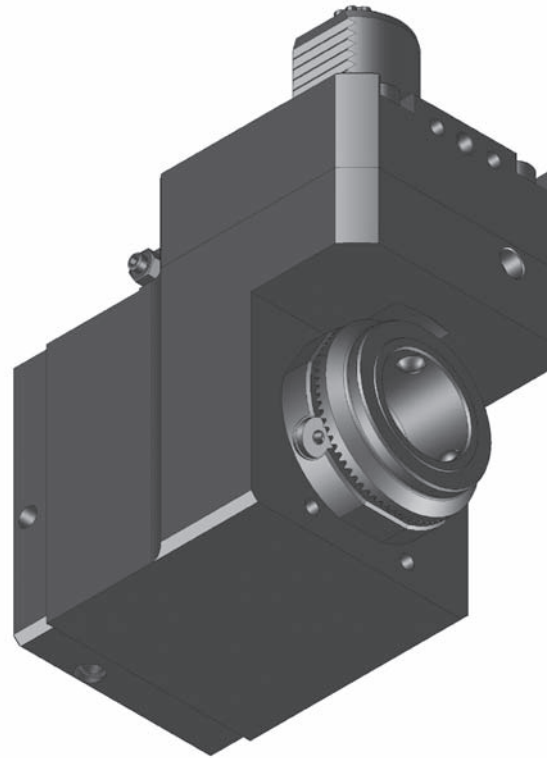
**DIN 5482 (B 17 x 14)**

Dimensions

Revolver type	Disc-type Turret
Shank	VDI 40
Drive	DIN 5482 B 17 x 14 Z = 9 Ø 16,5 mm

Modular Interfaces

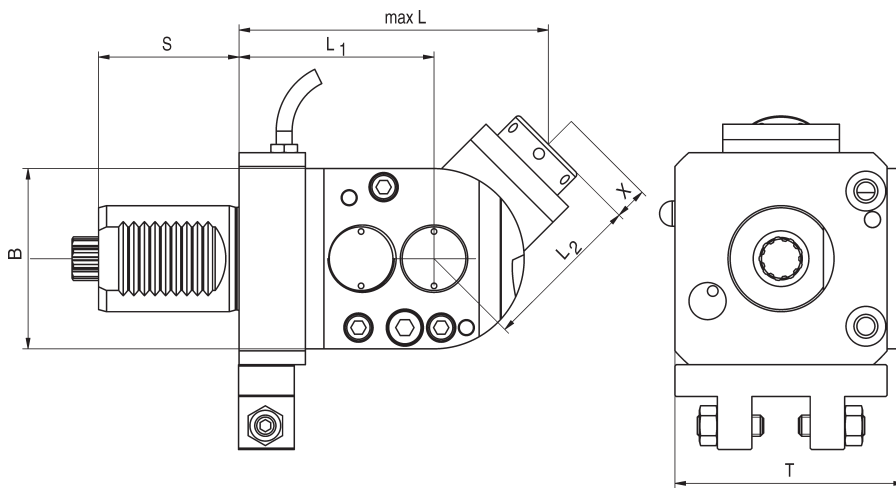
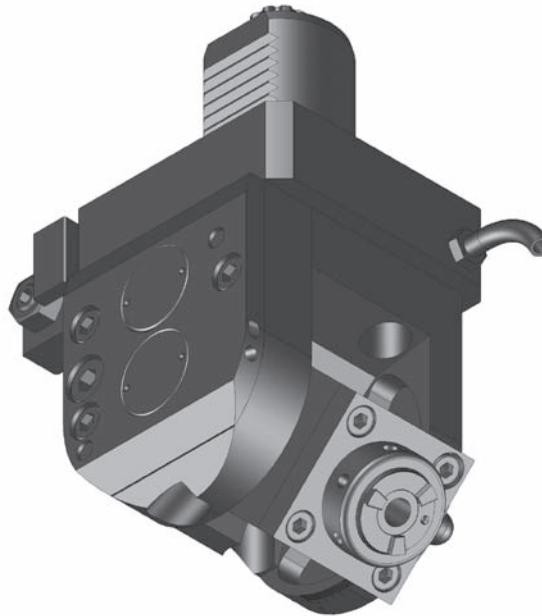
**mimaticMi**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124740	ER 32	1,0-20	25 Nm	6.500 / 6.500	i = 1:1	external	120	86	34	76,5	37	53	72	↺ ↻
124407	ER 32*	1,0-20	80 Nm	6.500 / 6.500	i = 1:1	internal	112	70	42	110,0	20	53	84	↺ ↻
124408	mi 50	-	100 Nm	4.000 / 4.000	i = 1:1	internal	145	100	45	107,5	31	53	96	↺ ↻

# Angle Unit, Adjustable 0-100°


for Turret Manufacturer	
with Drive	
<b>DIN 5482 (B 17 x 14)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 40
Drive	DIN 5482 B 17 x 14 Z = 9 Ø 16,5 mm

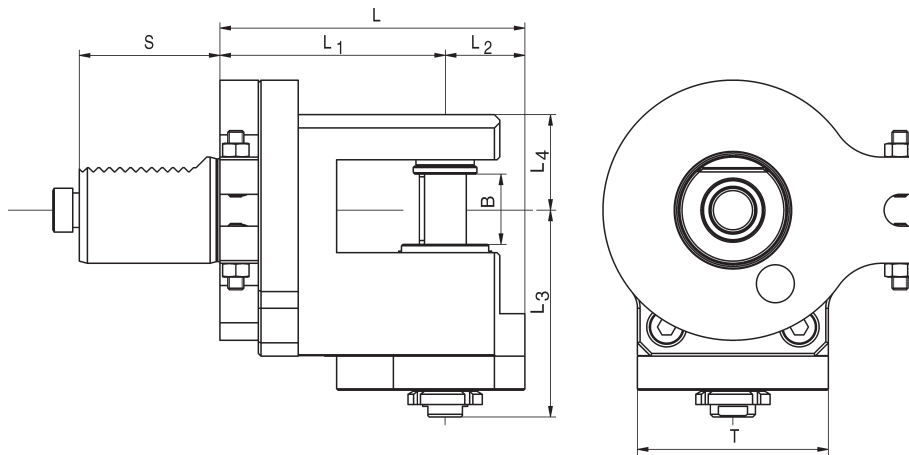
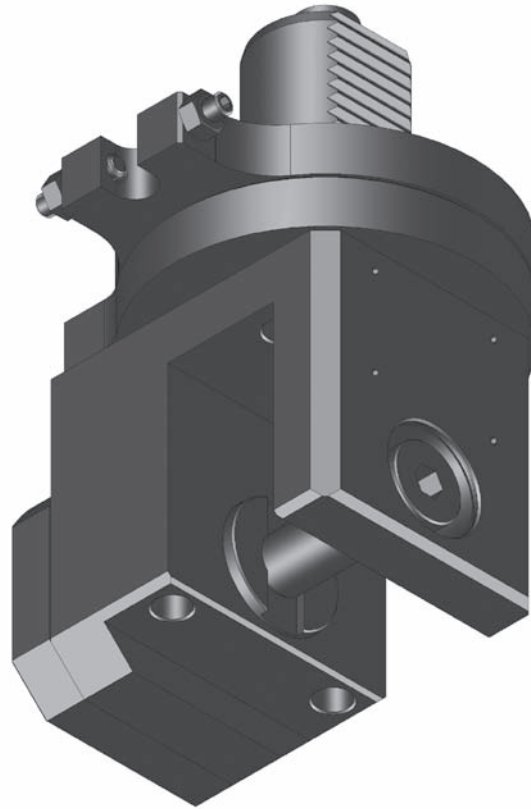


Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	B mm	S mm	T mm	Rotating direction
125009	ER 16	0,5-10	6 Nm	6.500 / 6.500	i = 1:1	external	134,5	73,5	61	92	53	90	

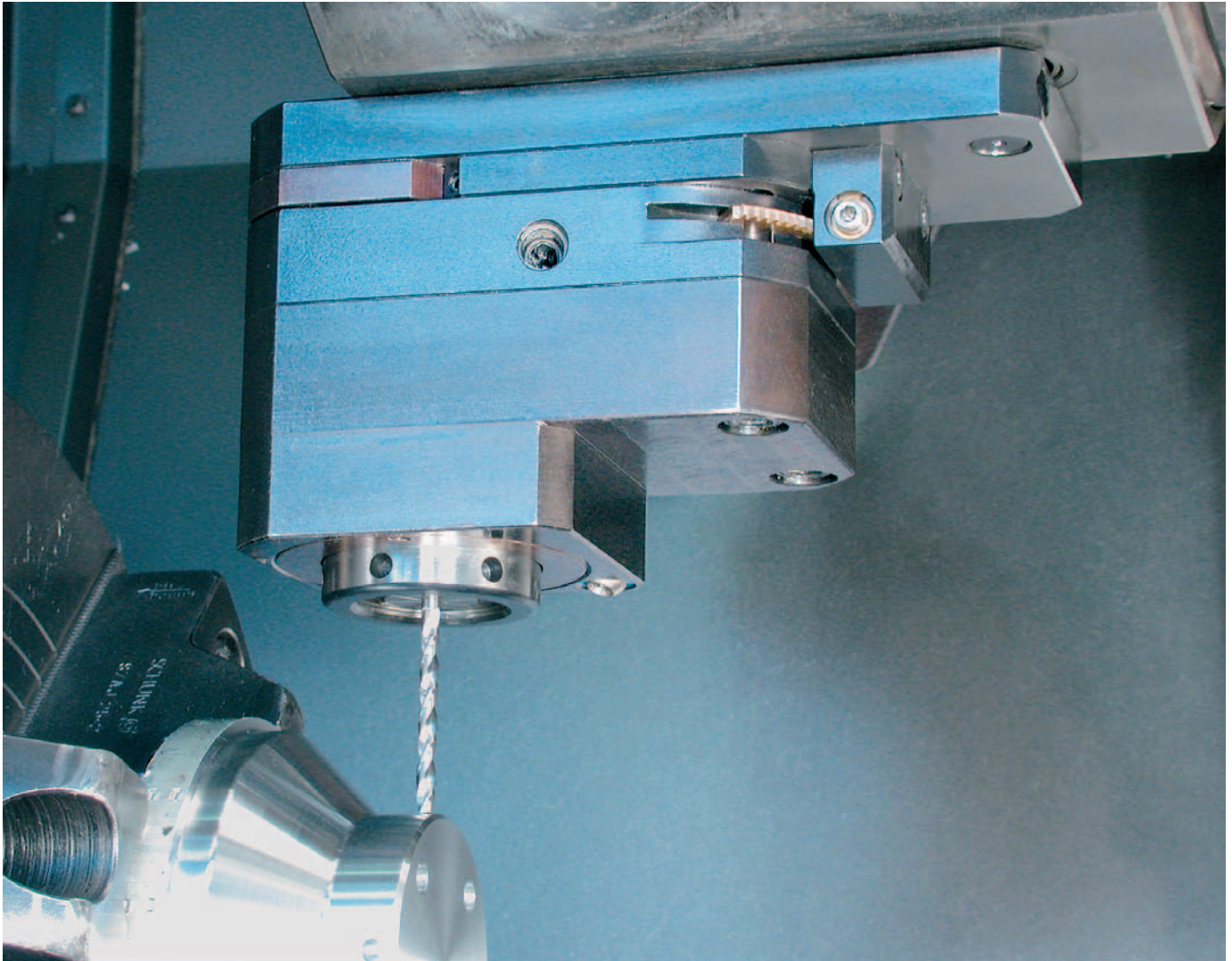


# Saw Blade Holder

for Turret Manufacturer	
	
with Drive	
<b>DIN 5482 (B 17 x 14)</b>	
Dimensions	
Turret type	Disc-type Turret
Shank	VDI 40
Drive	DIN 5482 B 17 x 14 Z = 9 Ø 16,5 mm



Order No.	Fitting dia. mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	B mm	S mm	T mm
125087*	22	20 Nm	6.500 / 2.450	i = 2,66:1	external	115	85	30	77,5	36	25	53	72
101810**	22	40 Nm	6.500 / 2.450	i = 2,66:1	external	130	95	35	87,5	36	25	53	72



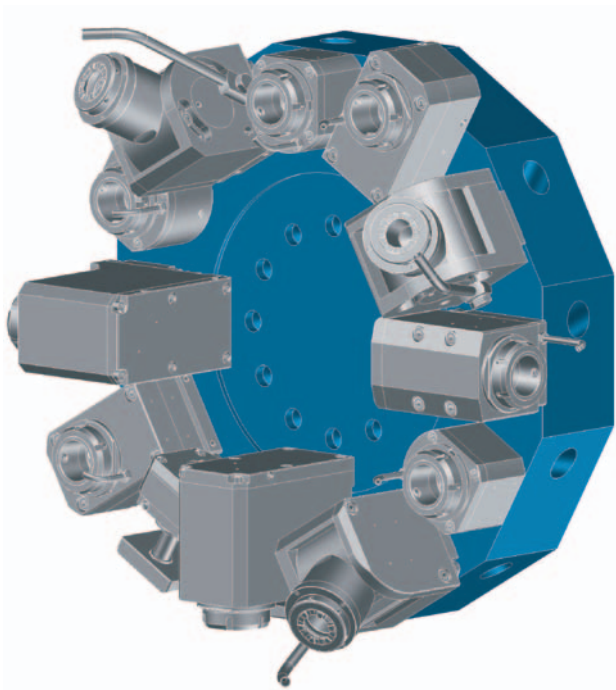
Picture shows a Y-axis driven toolholder with an adjustment range of  $\pm 50$  mm in Y-axis.

**Data**

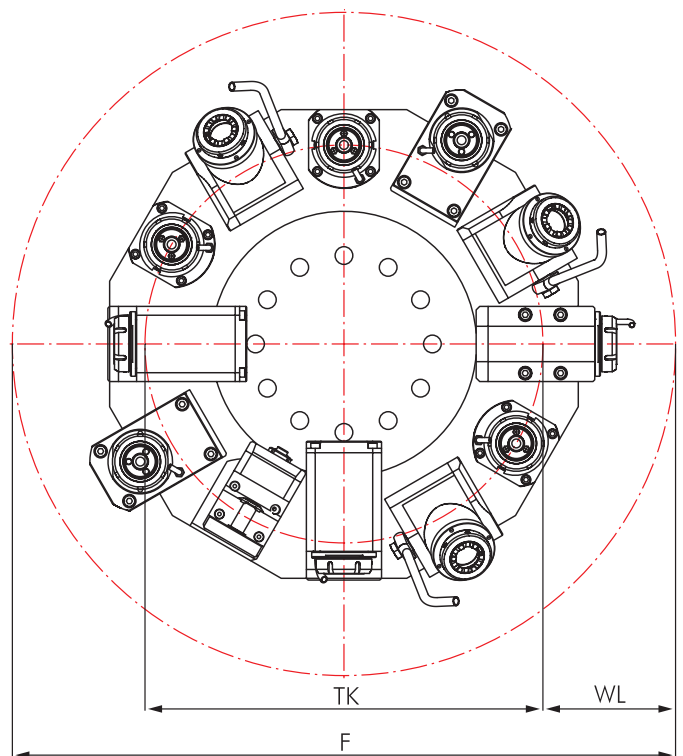
Disc-type Turret	Turret Stations
<b>Drive</b>	<b>DIN 5482 (B 20 x 17)</b>



**Disc-type Turret VDI 50**



**Interference Circles**



The interference circles are depending on your CNC machine. You can find it in your machine instruction manuals.

## Driven Toolholders

	Page		Page
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<b>Angle Unit, Offset Type</b>			30
<b>Angle Unit</b>	29		
<b>Angle Unit, adjustable 0-100°</b>			31
<b>Saw Blade Holder</b>			32

## Options and Accessories

<b>mi Toolholders</b>		mi System Description Toolholders Accessories	61 63-67 68-69
<b>Standard VDI Toolholders</b>		VDI Toolholders Accessories	80-86 87-89
<b>Accessories</b>		Collets DIN 6499 Threading Collets Wrenches Clamping Nuts Sleeves and Bushings	87 87 87 87 89



### Delivery information

Driven toolholders with mi quick-change interface are supplied with operating wrench (see spare parts on page 69).  
Driven toolholders with other interfaces are supplied without clamping wrench (see accessories on page 87).

# Straight Unit

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

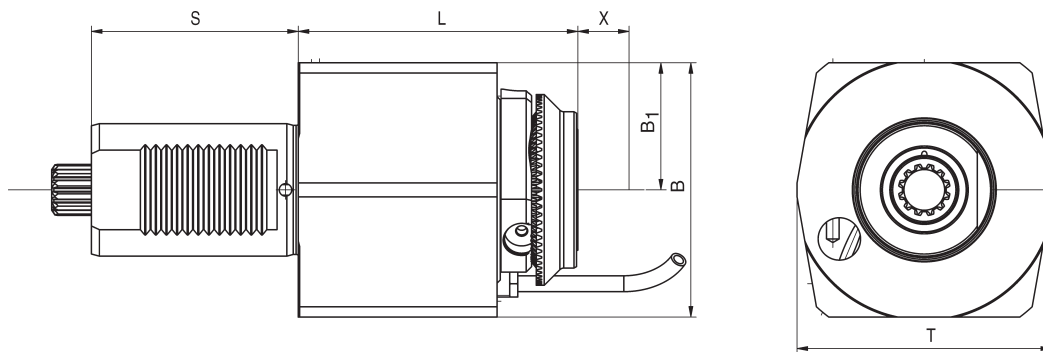
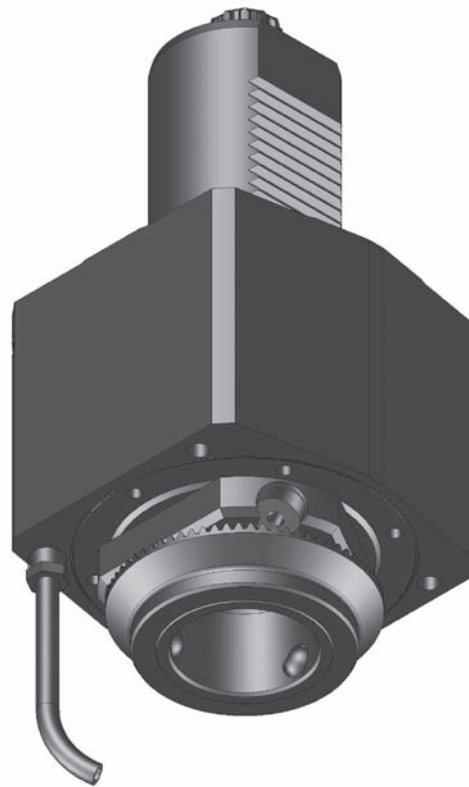
**DIN 5482 (B 20 x 17)**

Dimensions

Revolver type	Disc-type Turret
Shank	VDI 50
Drive	DIN 5482 B 20 x 17 Z = 12 Ø 19,5 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	B mm	B1 mm	S mm	T mm	Rotating direction
123815	ER 32	1,0-20	80 Nm	6.000 / 6.000	i = 1:1	external	86,0	96	48	78	96	↺ ↻
124188	ER 32*	1,0-20	80 Nm	5.200 / 5.200	i = 1:1	internal	86,0	96	48	78	96	↺ ↻
124191	mi 50	-	80 Nm	6.000 / 6.000	i = 1:1	internal	105,5	96	48	78	96	↺ ↻
124180	Hydro-Flex 20	6,0-20	80 Nm	6.000 / 6.000	i = 1:1	internal	104,0	96	48	78	96	↺ ↻

# Angle Unit

for Turret Manufacturer

**SAUTER**

with Drive

**DIN 5482 (B 20 x 17)**

Dimensions

Revolver type	Disc-type Turret
Shank	VDI 50
Drive	DIN 5482 B 20 x 17 Z = 12 Ø 19,5 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**

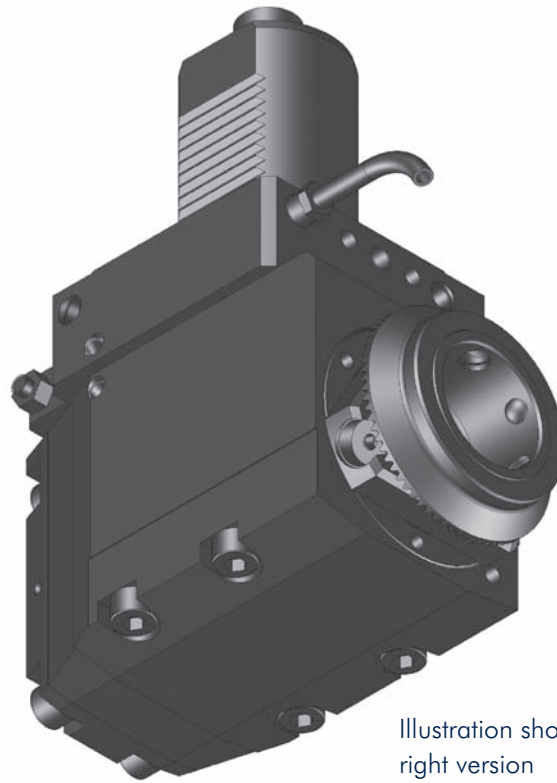
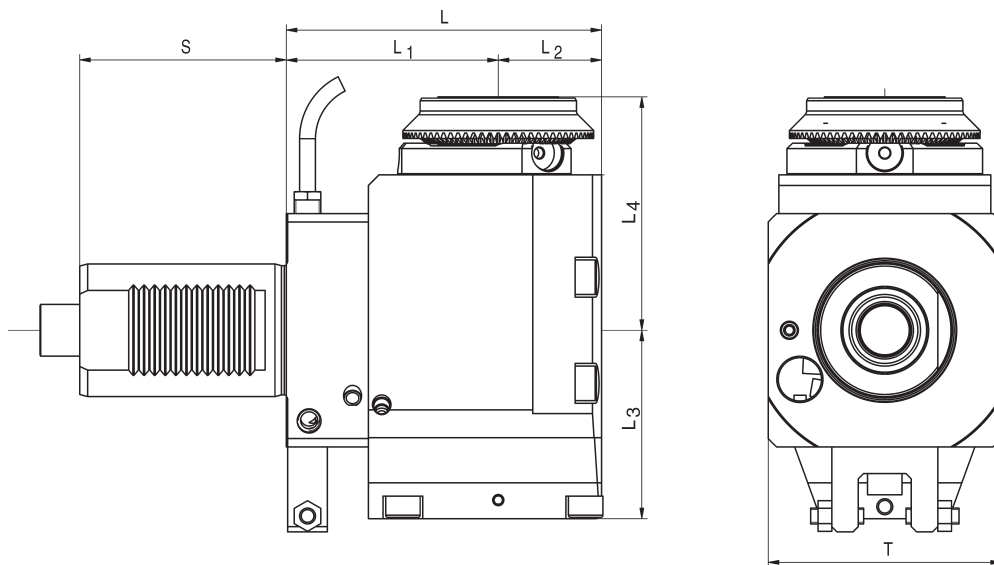


Illustration show right version



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124532	ER 32	1,0-20	80 Nm	5.200 / 5.200	i = 1:1	external	119	80	39	69,0	70	78	88	↺ ↻
124818	ER 32*	1,0-20	80 Nm	5.200 / 5.200	i = 1:1	internal	119	80	39	75,5	70	78	88	↺ ↻
124819	mi 50	-	80 Nm	6.500 / 6.500	i = 1:1	internal	123	80	43	75,5	88	78	88	↺ ↻
101443	Hydro-Flex 20	6,0-20	50 Nm	6.000 / 6.000	i = 1:1	internal	119	80	39	75,5	85	78	88	↺ ↻
171907**	Hydro-Flex 20	6,0-20	50 Nm	6.000 / 6.000	i = 1:1	internal	119	80	39	75,5	85	78	88	↺ ↻
124820**	mi 50	-	50 Nm	6.500 / 6.500	i = 1:1	internal	123	80	43	75,5	88	78	88	↺ ↻

\* With clamping nuts with sealing, seals see page 88      \*\* left version



# Angle Unit, Offset Type

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

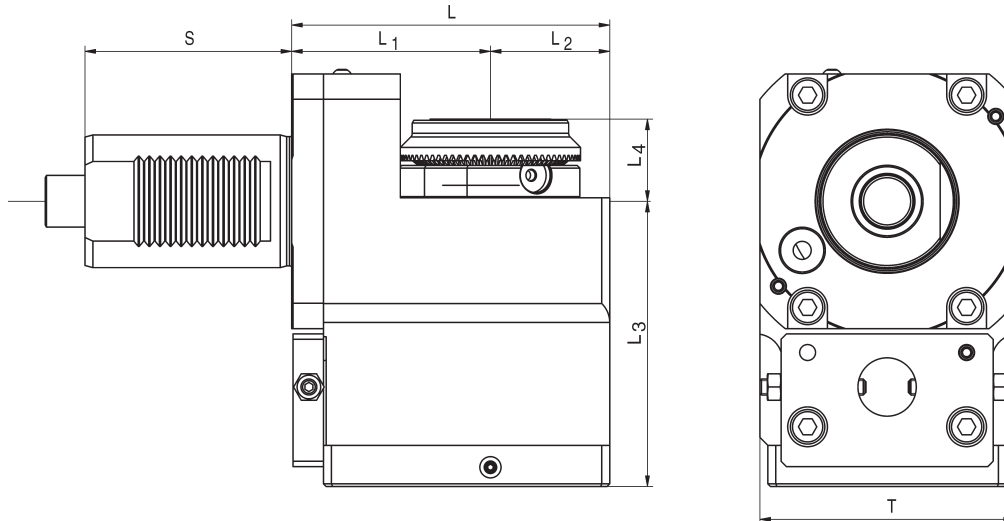
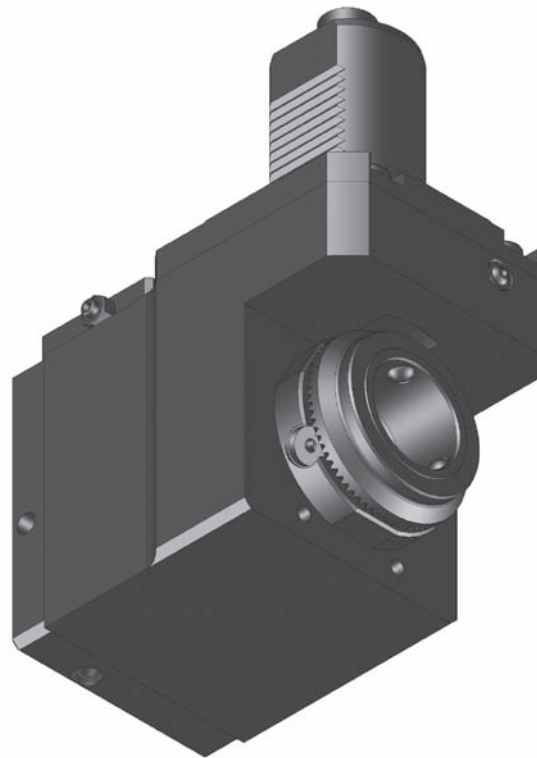
**DIN 5482 (B 20 x 17)**

Dimensions

Revolver type      Disc-type Turret  
Shank                VDI 50  
Drive                 DIN 5482  
                            B 20 x 17  
                            Z = 12  
                            Ø 19,5 mm

Modular Interfaces

**mimaticMi**

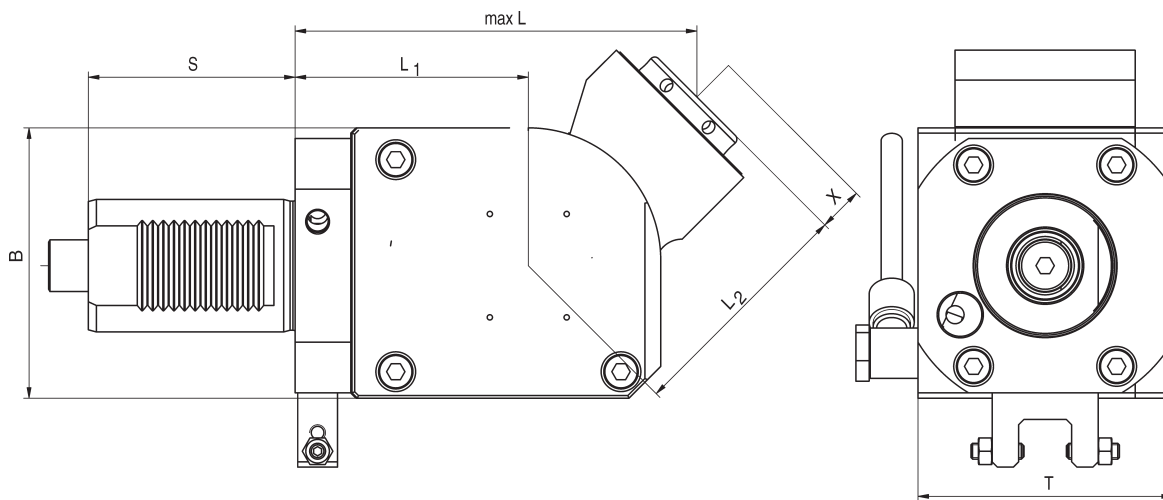
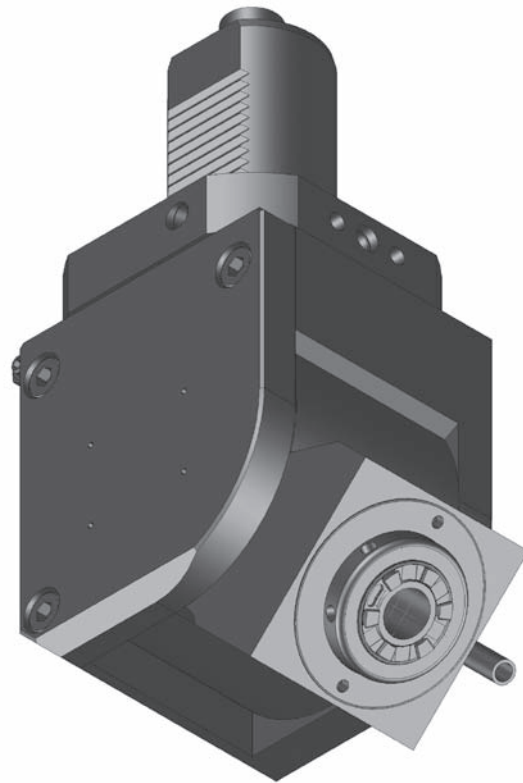


Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124745	ER 32	1,0-20	80 Nm	4.000 / 4.000	i = 1:1	external	112	70	42	111,0	20	78	84	↺ ↻
124414	ER 32*	1,0-20	80 Nm	4.000 / 4.000	i = 1:1	internal	112	70	42	111,0	20	78	84	↻ ↺
124415	mi 50	-	100 Nm	4.000 / 4.000	i = 1:1	internal	120	75	45	107,5	31	78	96	↻ ↺



# Angle Unit, Adjustable 0-100°

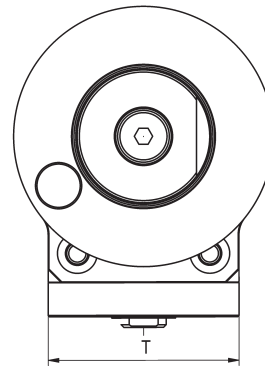
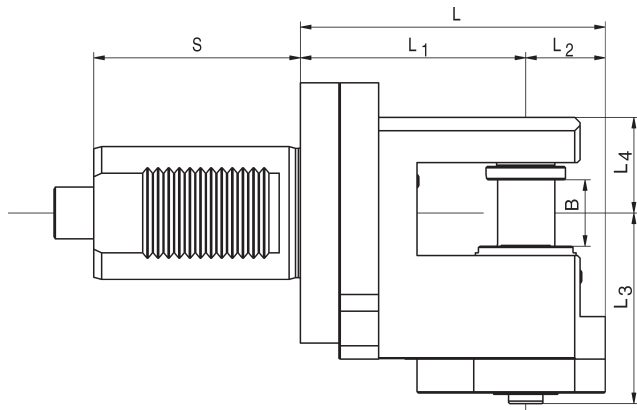
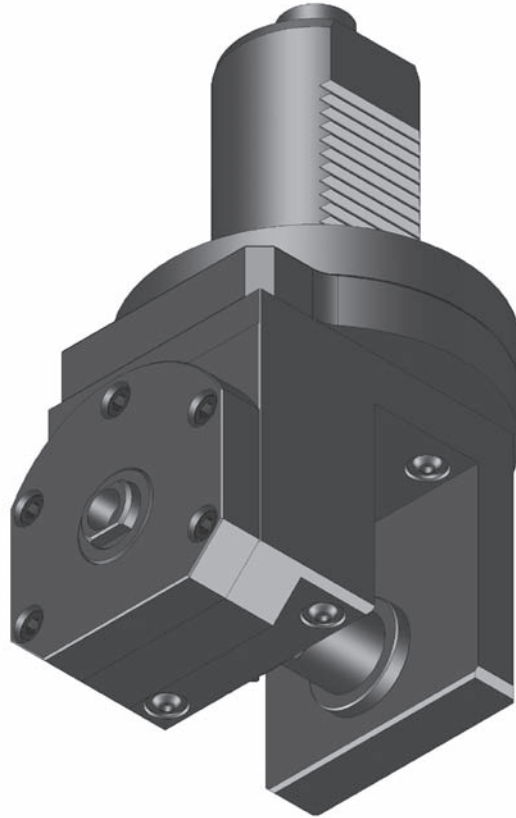
for Turret Manufacturer	
<b>SAUTER</b>	
with Drive	
<b>DIN 5482 (B 20 x 17)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 50
Drive	DIN 5482 B 20 x 17 Z = 12 Ø 19,5 mm



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	B mm	S mm	T mm	Rotating direction
101715	ER 25	0,5-16	35 Nm	6.500 / 6.500	i = 1:1	external	178	88	90	102	78	96	↻ ↻

# Saw Blade Holder

for Turret Manufacturer	
with Drive	
<b>DIN 5482 (B 20 x 17)</b>	
Dimensions	
Turret type	Disc-type Turret
Shank	VDI 50
Drive	DIN 5482 B 20 x 17 Z = 12 Ø 19,5 mm



Order No.	Fitting dia. mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	B mm	S mm	T mm
101812*	22	40 Nm	6.500 / 2.450	i = 2,66:1	external	130	95	35	87,5	36	25	78	72



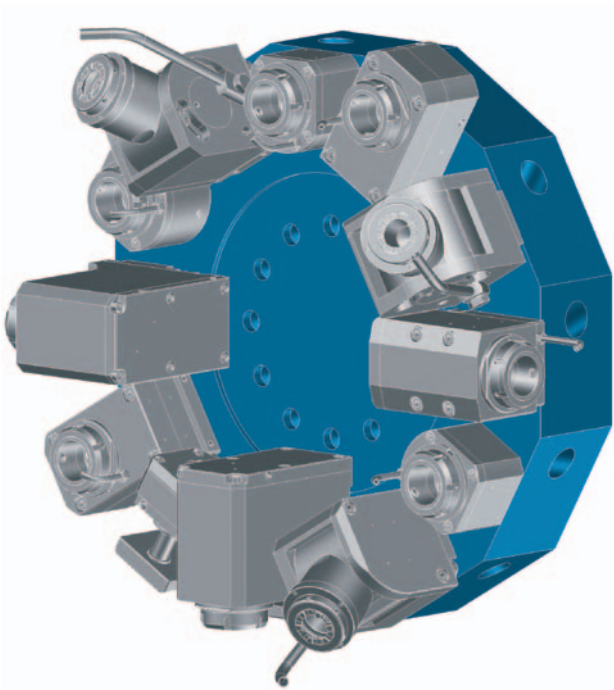
Picture shows a 90° angle head with ER 32 collet

**Data**

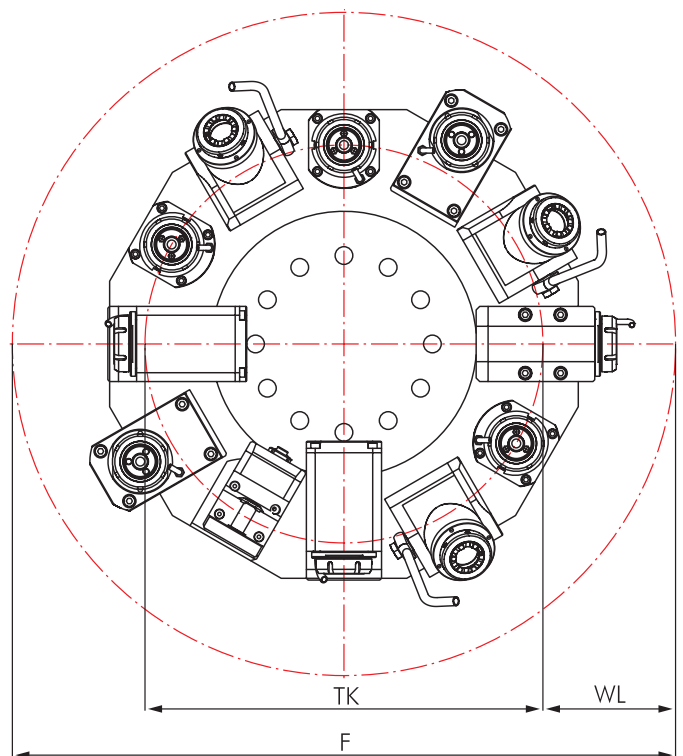
Disc-type Turret	Turret Stations
<b>Drive</b>	<b>DIN 5482 (B 25 x 22)</b>



**Disc-type Turret VDI 60**



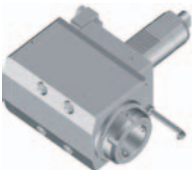


**Interference Circles**



The interference circles are depending on your CNC machine. You can find it in your machine instruction manuals.

## Driven Toolholders

	Page		Page		
<b>Straight Unit</b>		36	<b>Angle Unit, adjustable 0-100°</b>		38
<b>Angle Unit</b>		37			

## Options and Accessories

<b>mi Toolholders</b>		mi System Description Toolholders Accessories	61 63-67 68-69
<b>Standard VDI Toolholders</b>		VDI Toolholders Accessories	80-86 87-89
<b>Accessories</b>		Collets DIN 6499 Threading Collets Wrenches Clamping Nuts Sleeves and Bushings	87 87 87 87 89



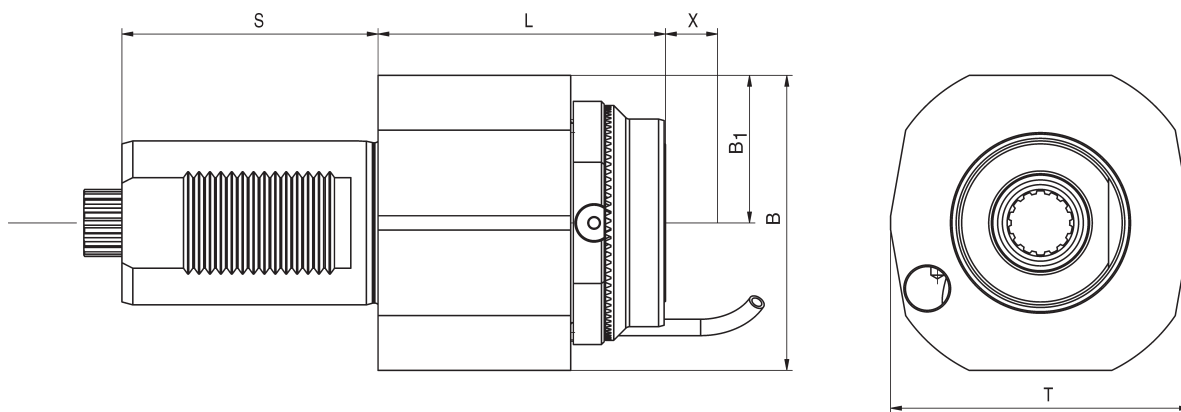
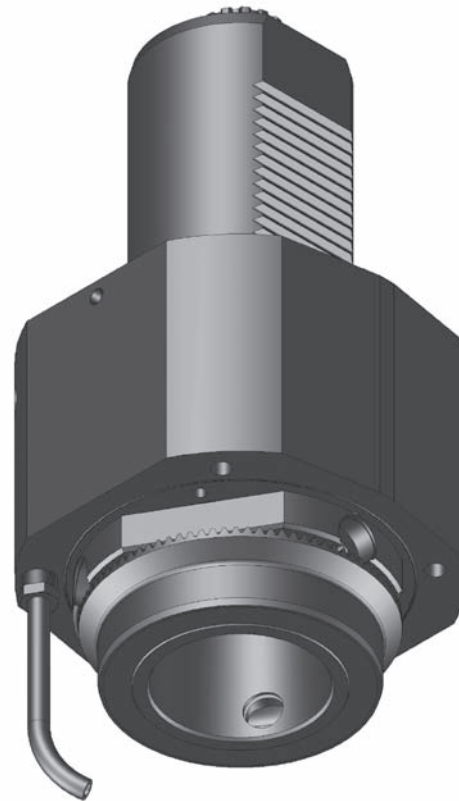
### Delivery information

Driven toolholders with mi quick-change interface are supplied with operating wrench (see spare parts on page 69).  
Driven toolholders with other interfaces are supplied without clamping wrench (see accessories on page 87).

# Straight Unit

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer	
<b>SAUTER</b>	
with Drive	
<b>DIN 5482 (B 25 x 22)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 60
Drive	DIN 5482 B 25 x 22 Z = 14 Ø 24,5 mm
Modular Interfaces	
<b>mimaticMi</b>	



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	B mm	B1 mm	S mm	T mm	Rotating direction
123820	ER 40	3,0-26	140 Nm	4.000 / 4.000	i = 1:1	external	118,0	108	54	94	104	↻ ↻
124204	ER 40	3,0-26	140 Nm	4.000 / 4.000	i = 1:1	internal	123,0	106	52	94	96	↻ ↻
124206	mi 63	-	140 Nm	4.000 / 4.000	i = 1:1	internal	105,5	108	54	94	110	↻ ↻

# Angle Unit

for Turret Manufacturer	
<b>SAUTER</b>	
with Drive	
<b>DIN 5482 (B 25 x 22)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 60
Drive	DIN 5482 B 25 x 22 Z = 14 Ø 24,5 mm
Modular Interfaces	
<b>mimaticMi</b>	

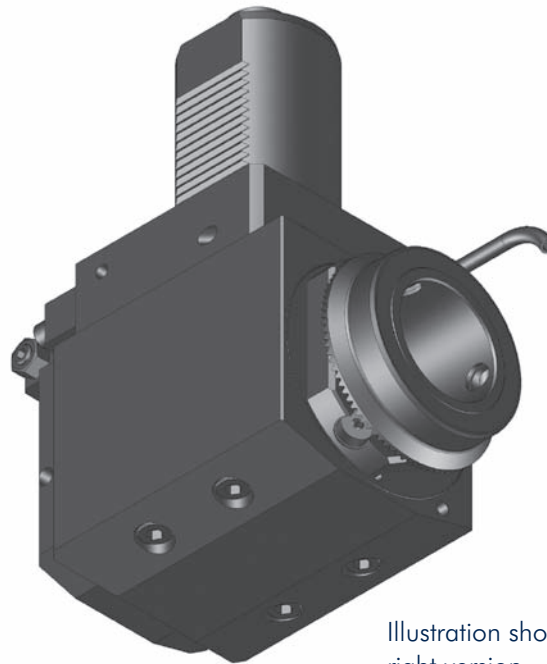
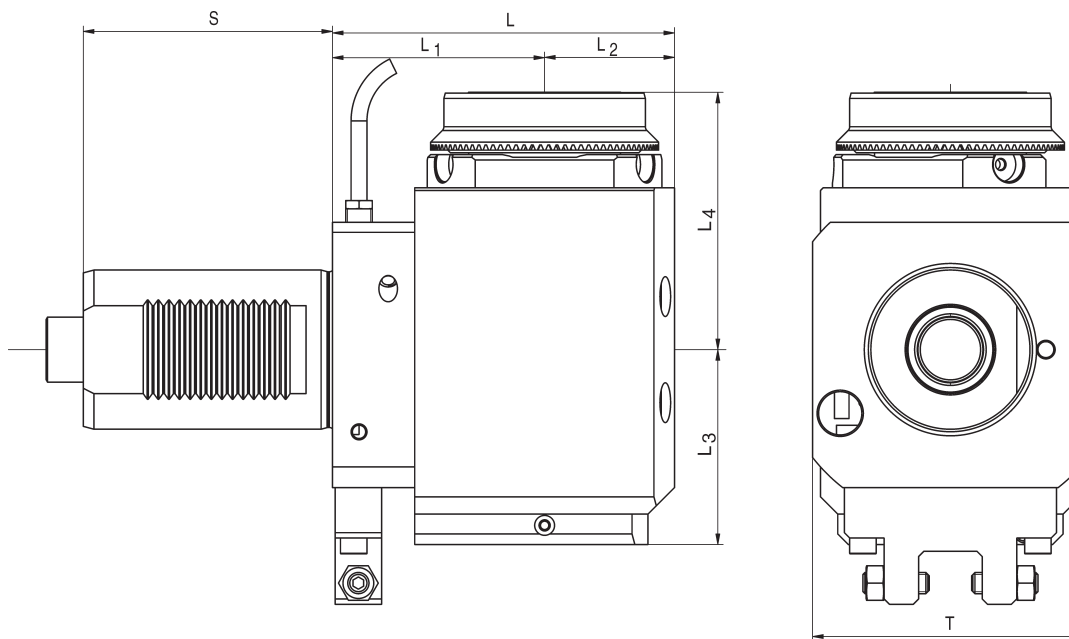


Illustration shows right version



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
124537	ER 40	3,0-26	80 Nm	5.200 / 5.200	i = 1:1	external	135	85	50	69,0	107,5	94	100	↺ ↻
101453	ER 40*	3,0-26	80 Nm	6.000 / 6.000	i = 1:1	internal	129	80	49	73,5	107,5	94	100	↻ ↺
124823	mi 63	-	80 Nm	4.000 / 4.000	i = 1:1	internal	130	80	50	73,5	97,0	94	105	↺ ↻
133738*	mi 63*	-	80 Nm	4.000 / 4.000	i = 1:1	internal	130	80	50	73,5	97,0	94	102	↻ ↺

\* With clamping nuts with sealing, seals see page 88      \*\* left version



# Angle Unit, Adjustable 0-100°

for Turret Manufacturer	
with Drive	
<b>DIN 5482 (B 25 x 22)</b>	
Dimensions	
Revolver type	Disc-type Turret
Shank	VDI 60
Drive	DIN 5482 B 25 x 22 Z = 14 Ø 24,5 mm

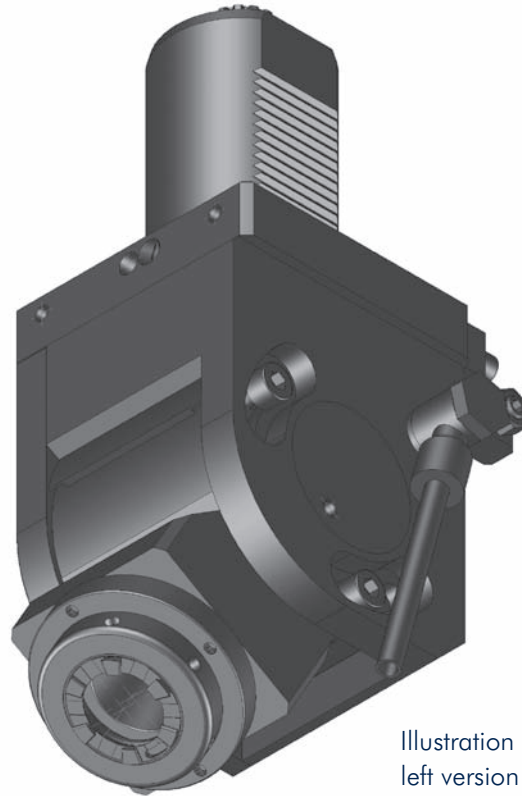
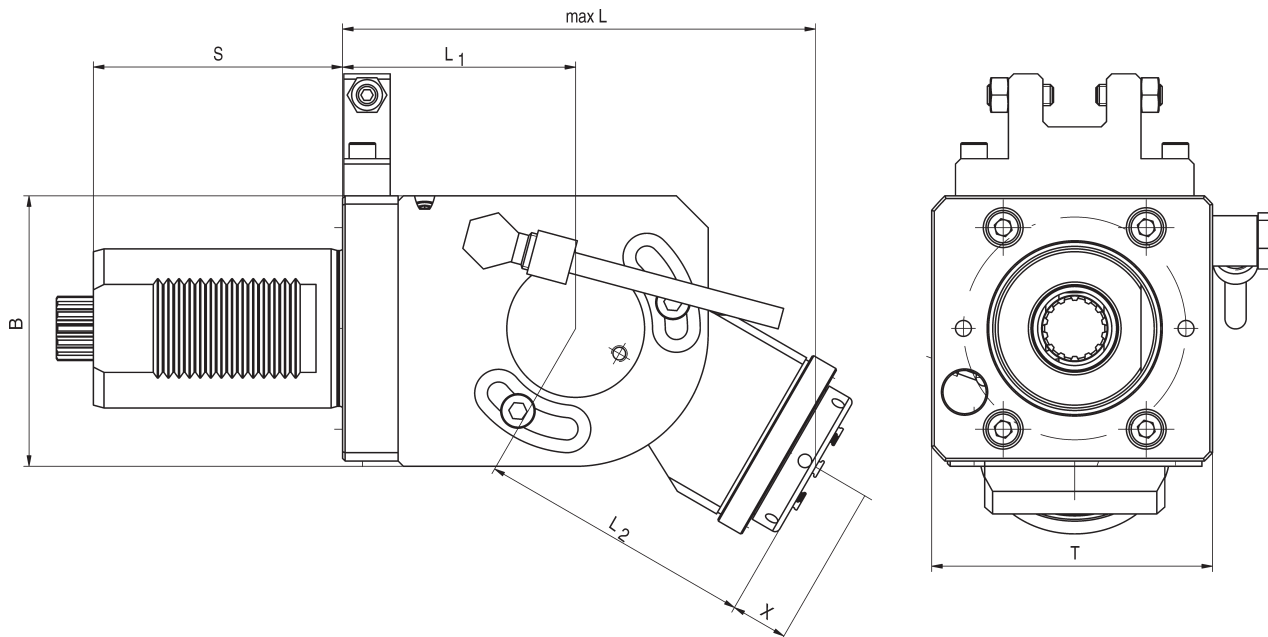
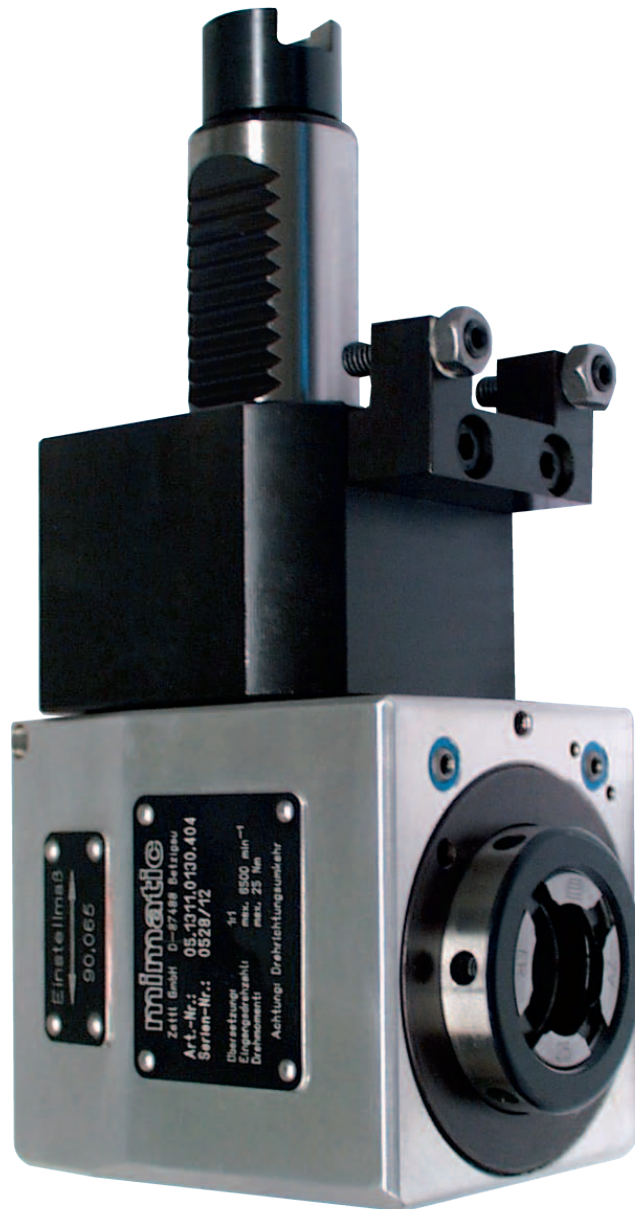


Illustration shows left version



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	B mm	S mm	T mm	Rotating direction
<b>left version:</b>													
169310	ER 32	1,0-20	35 Nm	6.000 / 6.000	i = 1:1	external	192,5	88	104,5	106	94	106	
<b>right version:</b>													
175813	ER 32	1,0-20	35 Nm	6.000 / 6.000	i = 1:1	external	192,5	88	104,5	106	94	106	



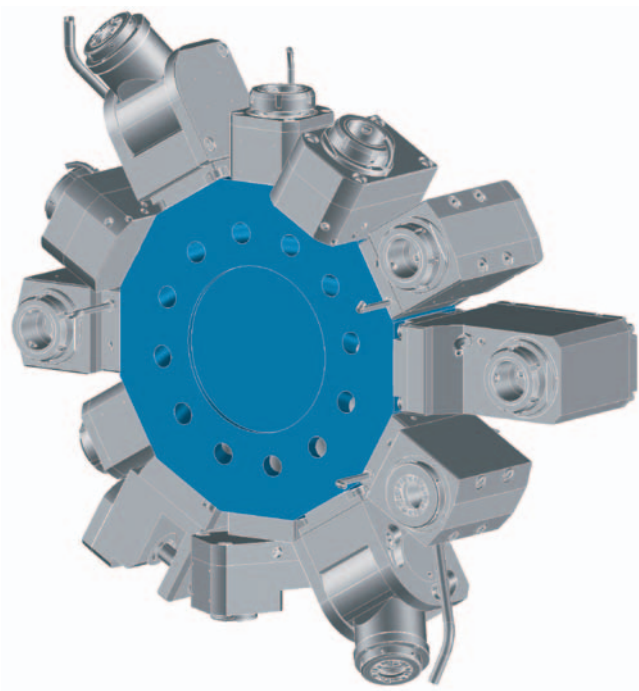
Picture shows a 90° angle head with ER 25 collet

**Data**

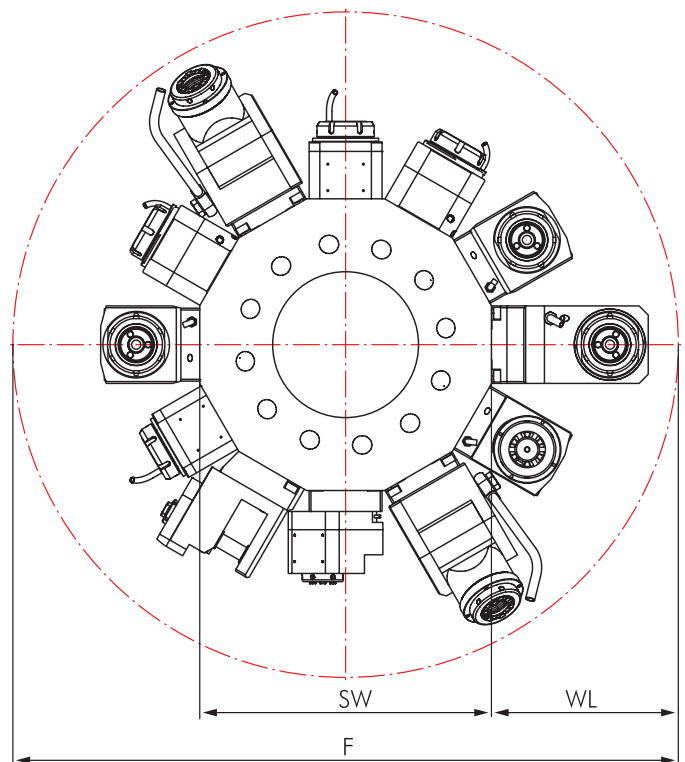
Star-type Turret	Turret Stations
<b>Drive</b>	<b>DIN 5480 (W16x0,8x30x18/9b)</b>



**Star-type Turret VDI 30**



**Interference Circles**



The interference circles are depending on your CNC machine. You can find it in your machine instruction manuals.

**Driven Toolholders**

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<b>Angle Unit, 2-Axis</b>			47
<b>Angle Unit</b>	43-44		
<b>Angle Unit, adjustable 0-100°</b>			48
<b>Angle Unit, Offset Type</b>	45-46		
<b>Saw Blade Holder</b>			49

**Options and Accessories**

<b>mi Toolholders</b>		mi System Description Toolholders Accessories	61 63-67 68-69
<b>Static Toolholders for SAUTER</b>		Static Toolholders Accessories	74-77 78
<b>Accessories</b>		Collets DIN 6499 Threading Collets Wrenches Clamping Nuts Sleeves and Bushings	87 87 87 87 89



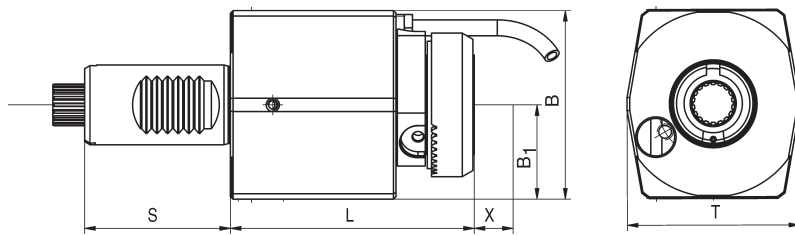
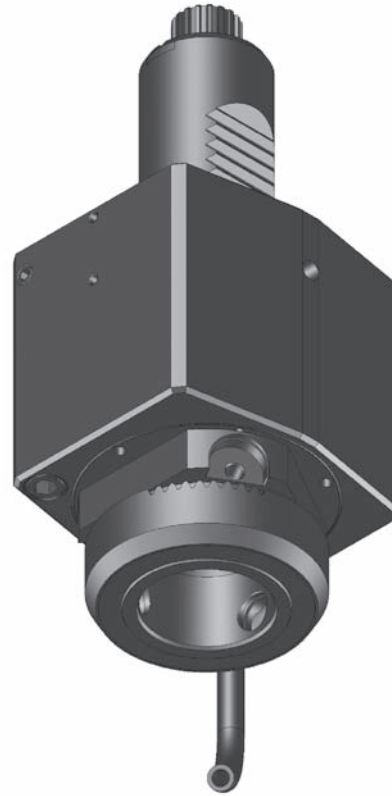
**Delivery information**

Driven toolholders with mi quick-change interface are supplied with operating wrench (see spare parts on page 69).  
Driven toolholders with other interfaces are supplied without clamping wrench (see accessories on page 87).

# Straight Unit

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 16 x 0,8 x 30 x 18 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16x0,8x30x18 / 9b Ø 15,9 mm
Modular Interfaces	



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	B mm	B1 mm	S mm	T mm	Rotating direction
133756	ER 25	0,5-16	40 Nm	6.500 / 6.500	i = 1:1	external	73	71	35	55	65	
133736	ER 25*	0,5-16	40 Nm	6.500 / 6.500	i = 1:1	internal	73	71	35	55	65	
133762	mi 40	-	40 Nm	6.500 / 6.500	i = 1:1	internal	92	71	35	55	65	

# Angle Unit, Right-hand Version

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

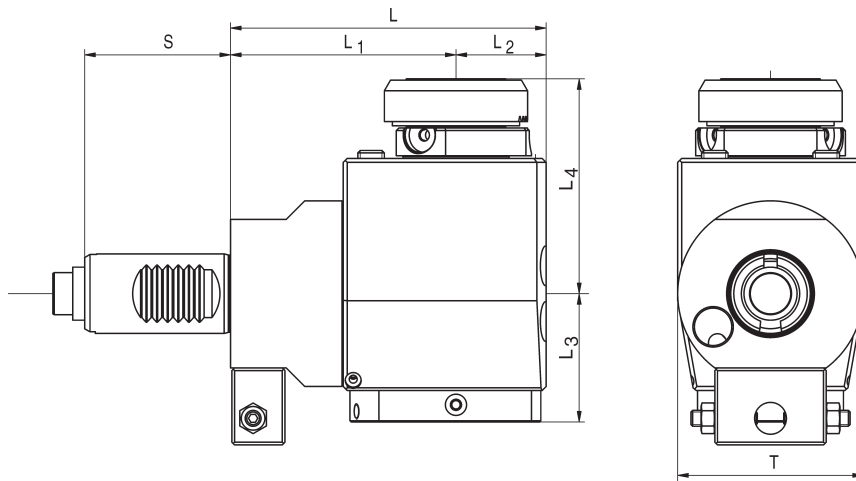
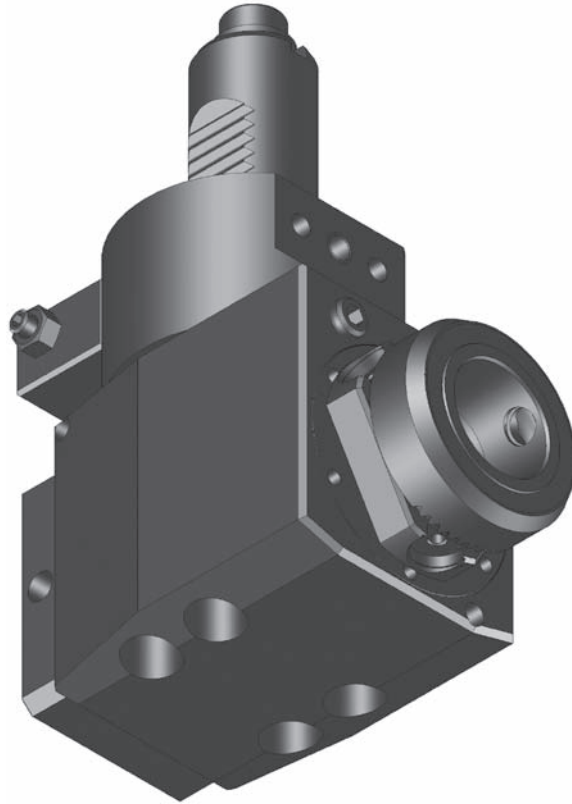
**DIN 5480  
(W 16 x 0,8 x 30 x 18 / 9b)**

Dimensions

Revolver type Star-type Turret  
Shank VDI 30  
Drive DIN 5480  
with spindle orientation  
detent  
W 16 x 0,8 x 30 x 18 / 9b  
Ø 15,9 mm

Modular Interfaces

**mimaticMi**

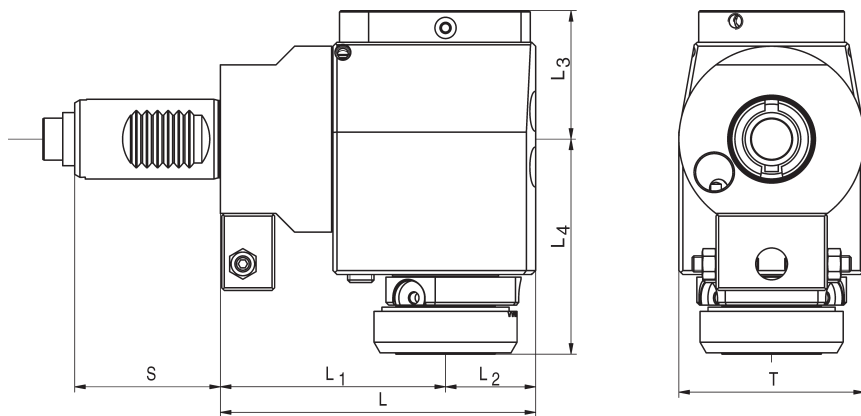
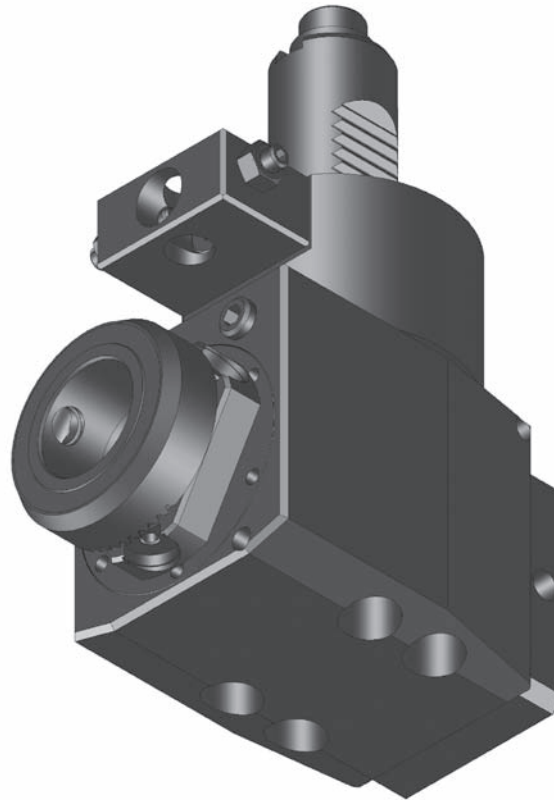


Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
103554	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	89	55	34	36,5	60,0	55	70	↺ ↻
103536	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	89	55	34	36,5	60,0	55	70	↻ ↺
168443	ER 25*	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	90	55	35	62,0	72,5	55	70	↺ ↻
133763	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	119	85	34	36,5	60,0	55	70	↺ ↻
133739	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	119	85	34	36,5	60,0	55	70	↻ ↺
133733	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	119	85	34	48,5	81,0	55	70	↺ ↻
133771	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	134	100	34	36,5	60,0	55	70	↺ ↻
133772	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	134	100	34	36,5	60,0	55	70	↻ ↺
133764	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	134	100	34	48,5	81,0	55	70	↺ ↻
171413	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	119	85	34	36,5	60,0	55	70	↺ ↻

\* With clamping nuts with sealing, seals see page 88

# Angle Unit, Left-hand Version

for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 16 x 0,8 x 30 x 18 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16 x 0,8 x 30 x 18 / 9b Ø 15,9 mm
Modular Interfaces	

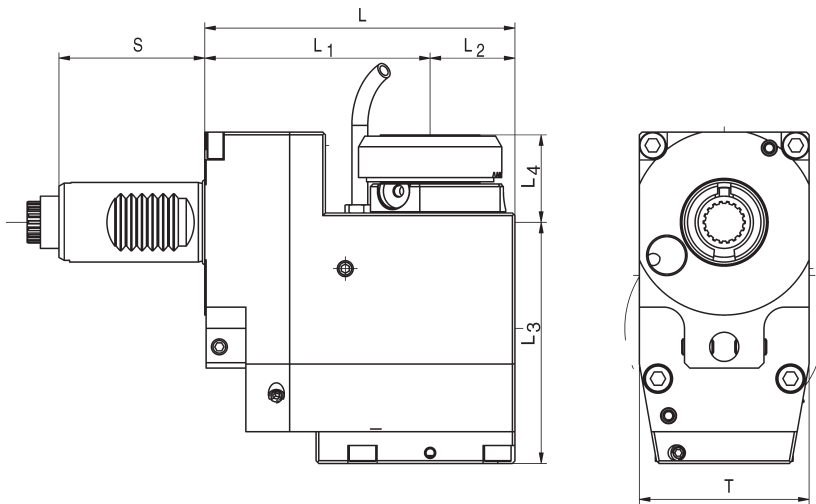
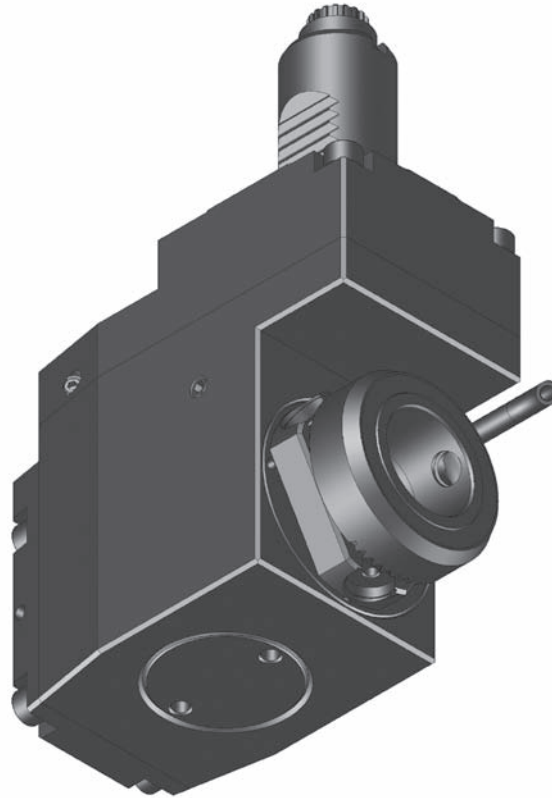


Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
103545	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	89	55	34	36,5	60,0	55	70	
103515	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	89	55	34	36,5	60,0	55	70	
133730	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	119	85	34	36,5	60,0	55	70	
133731	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	119	85	34	36,5	60,0	55	70	
133732	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	119	85	34	48,4	81,0	55	70	
168324	ER 25	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	external	120	85	95	62,0	72,5	55	70	
168444	ER 25*	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	135	85	35	62,0	72,5	55	70	
133766	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	external	134	100	34	48,0	81,0	55	70	
103507	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	134	100	34	36,5	60,0	55	70	
133747	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	134	100	34	36,5	60,0	55	70	
168325	ER 25	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	135	100	35	62,0	72,5	55	70	
168445	ER 25*	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	135	100	35	62,0	72,5	55	70	



# Angle Unit, Offset Type, Right-hand Version

for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 16 x 0,8 x 30 x 18 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16 x 0,8 x 30 x 18 / 9b Ø 15,9 mm
Modular Interfaces	

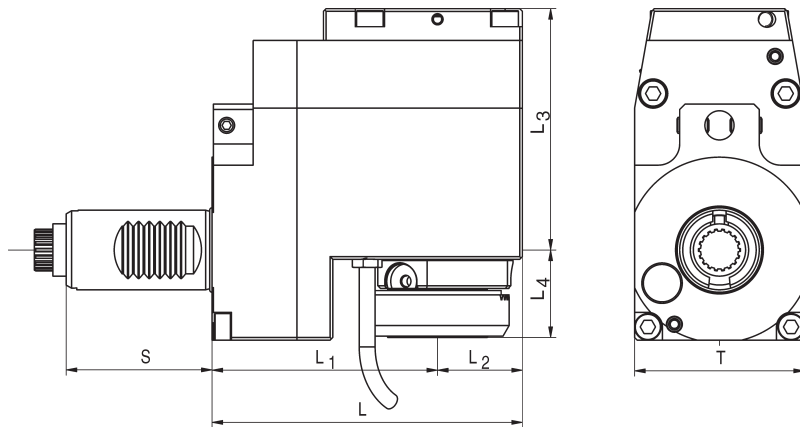
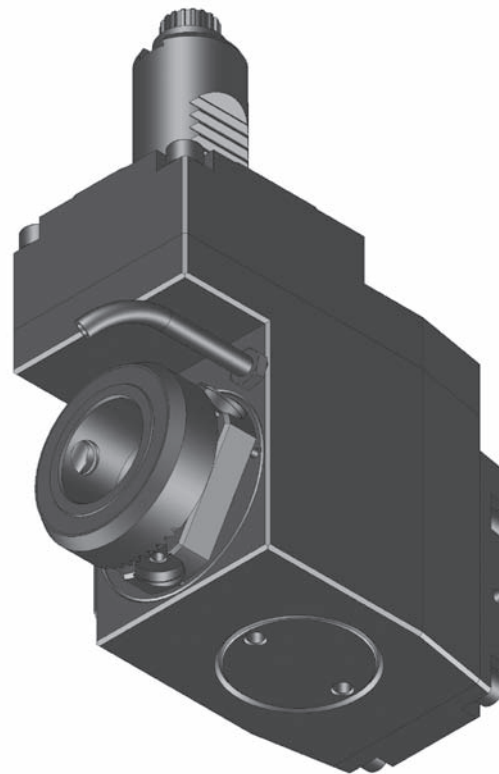


Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
103539	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	117	85	32	91	15	55	64	
103555	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	117	85	32	91	15	55	64	
169187	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	117	85	32	91	33	55	64	
103546	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	132	100	32	91	15	55	64	
103547	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	132	100	32	91	15	55	64	

\* With clamping nuts with sealing, seals see page 88

# Angle Unit, Offset Type, Left-hand Version

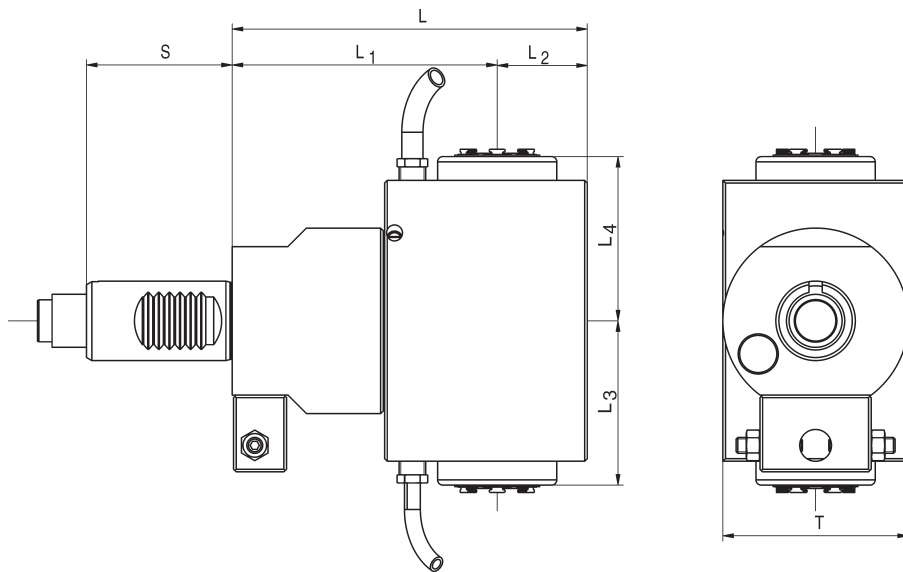
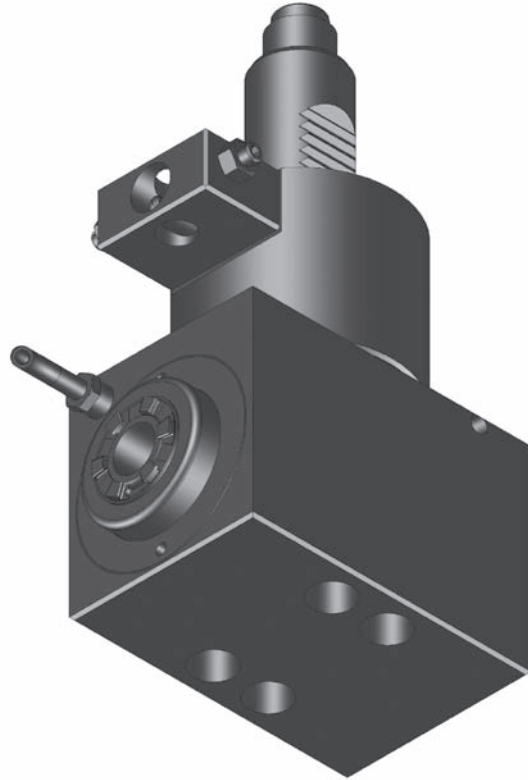
for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 16 x 0,8 x 30 x 18 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16 x 0,8 x 30 x 18 / 9b Ø 15,9 mm
Modular Interfaces	



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
103526	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	117	85	32	91	20	55	64	
103565	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	117	85	32	91	20	55	64	
169191	mi 40	-	25 Nm	6.500 / 6.500	i = 1:1	internal	117	85	32	91	33	55	64	
103551	ER 25	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	external	132	100	32	91	20	55	64	
103517	ER 25*	0,5-16	25 Nm	6.500 / 6.500	i = 1:1	internal	132	100	32	91	20	55	64	

# Angle Unit, 2-Axis

for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 16 x 0,8 x 30 x 18 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16 x 0,8 x 30 x 18 / 9b Ø 15,9 mm



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm
103622	2x ER 25	0,5-16	20 Nm	6.500 / 6.500	i = 1:1	external	119	85	34	62	62	55	70
103556	2x ER 25	0,5-16	20 Nm	6.500 / 6.500	i = 1:1	external	134	100	34	62	62	55	70

# Angle Unit, Adjustable 0-100°

for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 16 x 0,8 x 30 x 18 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16x0,8x30x18 / 9b Ø 15,9 mm

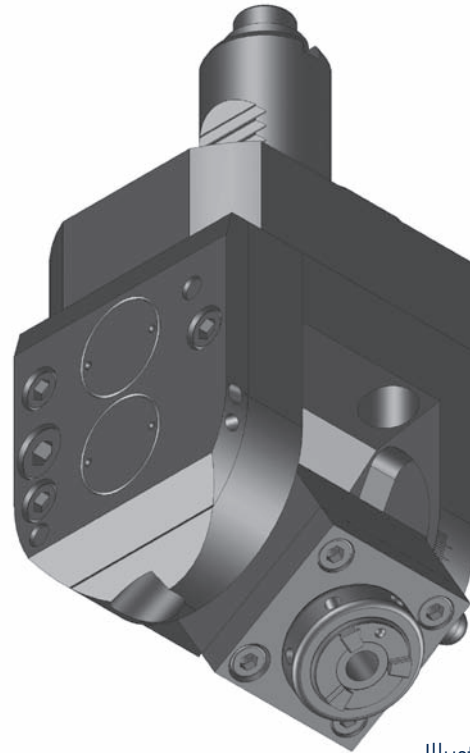
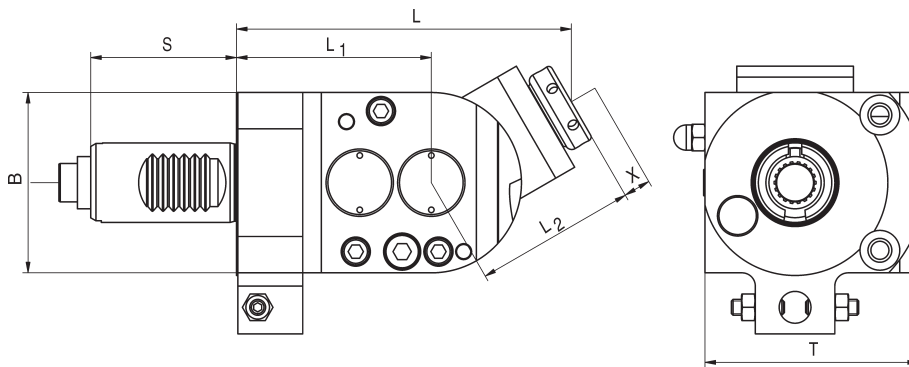


Illustration shows right version



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	B mm	S mm	T mm	Rotating direction
right version:													
103566	ER 16	0,5-10	6 Nm	6.500 / 6.500	i = 1:1	external	138	73,5	64,5	68	55	80,5	↻ ↻
left version:													
125008	ER 16	0,5-10	6 Nm	6.500 / 6.500	i = 1:1	external	138	73,5	64,5	68	55	80,5	↻ ↻

# Saw Blade Holder

for Turret Manufacturer

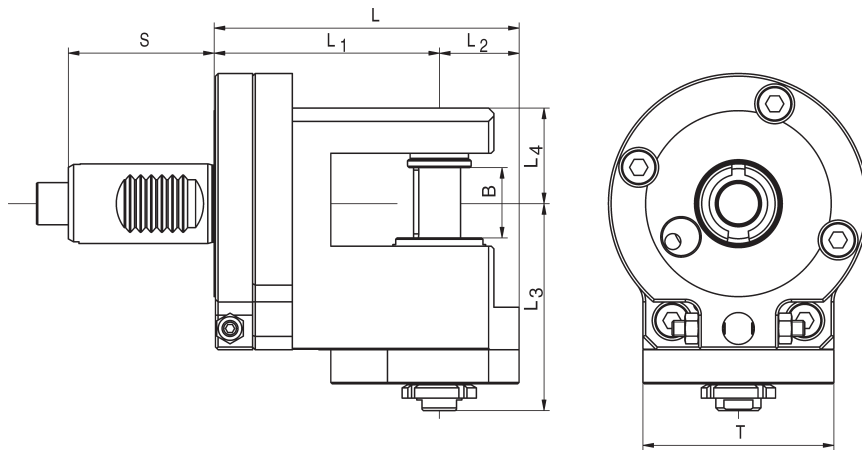
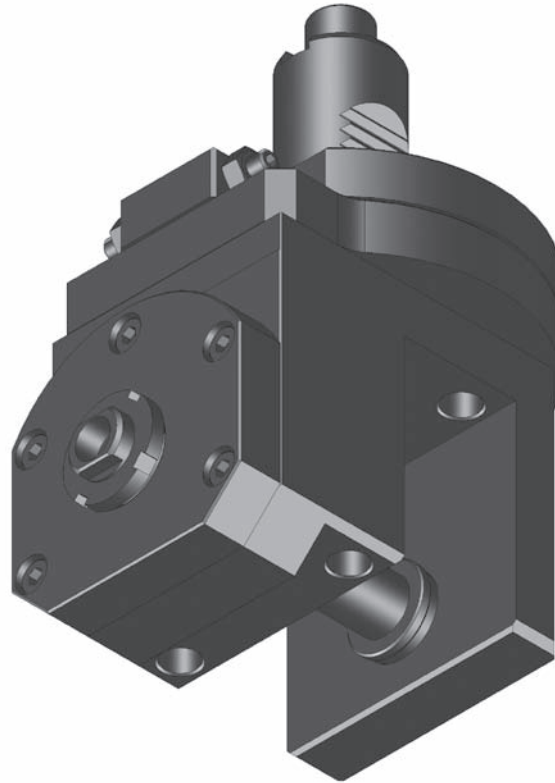
**SAUTER**

with Drive

**DIN 5480**  
**(W 16 x 0,8 x 30 x 18 / 9b)**

Dimensions

Revolver type	Star-type Turret
Shank	VDI 30
Drive	DIN 5480 with spindle orientation detent W 16x0,8x30x18 / 9b Ø 15,9 mm



Order No.	Fitting dia. mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	B mm	S mm	T mm
133767*	16	20 Nm	6.500 / 2.450	i = 2,66:1	external	115	85	30	78	36	25	55	104

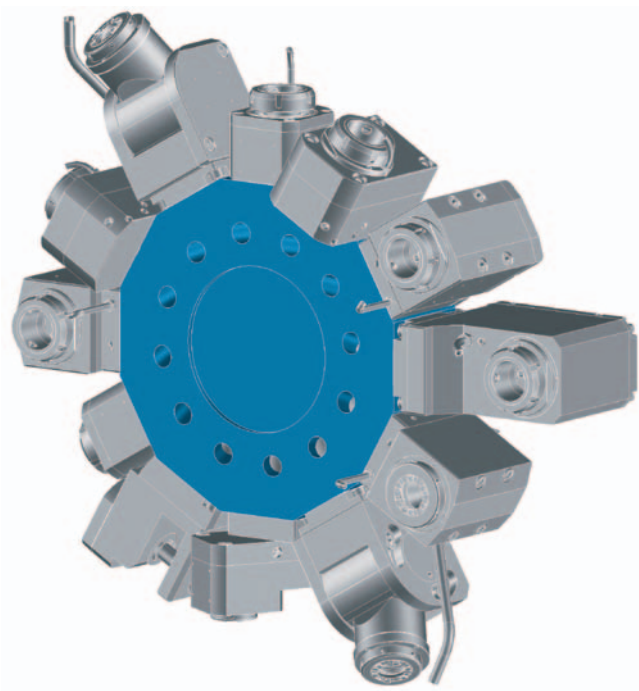
\* Saw blade diameter max. = 80 mm

**Data**

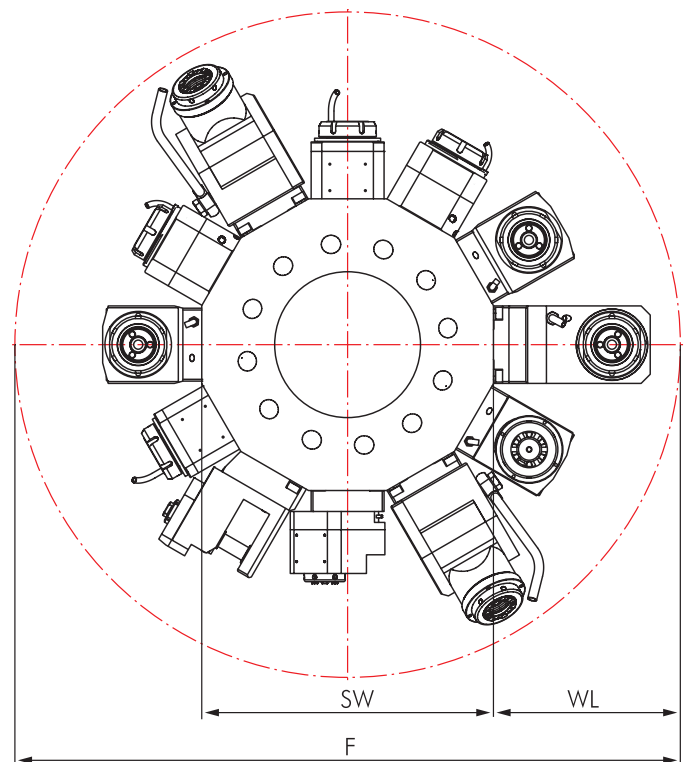
Star-type Turret	Turret Stations
Drive	DIN 5480 (W20x0,8x30x24/9b)



**Star-type Turret VDI 40**



**Interference Circles**



The interference circles are depending on your CNC machine. You can find it in your machine instruction manuals.

**Driven Toolholders**

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<b>Straight Unit</b>	52		
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<b>Saw Blade Holder</b>			59

**Options and Accessories**

<b>mi Toolholders</b>		mi System Description Toolholders Accessories	61 63-67 68-69
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<b>Accessories</b>		Collets DIN 6499 Threading Collets Wrenches Clamping Nuts Sleeves and Bushings	87 87 87 87 89



**Delivery information**

Driven toolholders with mi quick-change interface are supplied with operating wrench (see spare parts on page 69).  
Driven toolholders with other interfaces are supplied without clamping wrench (see accessories on page 87).



# Straight Unit

Connectable accessories with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

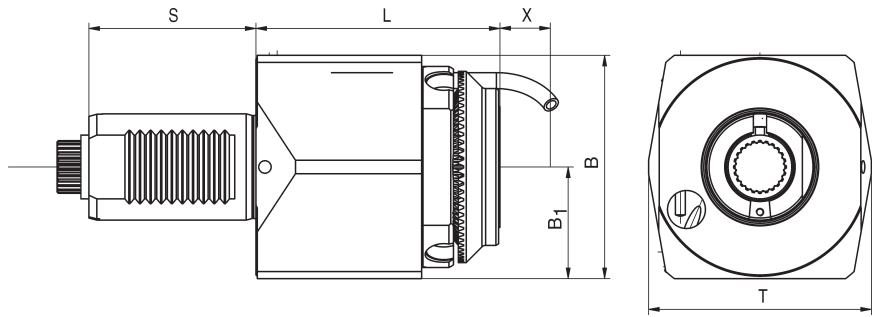
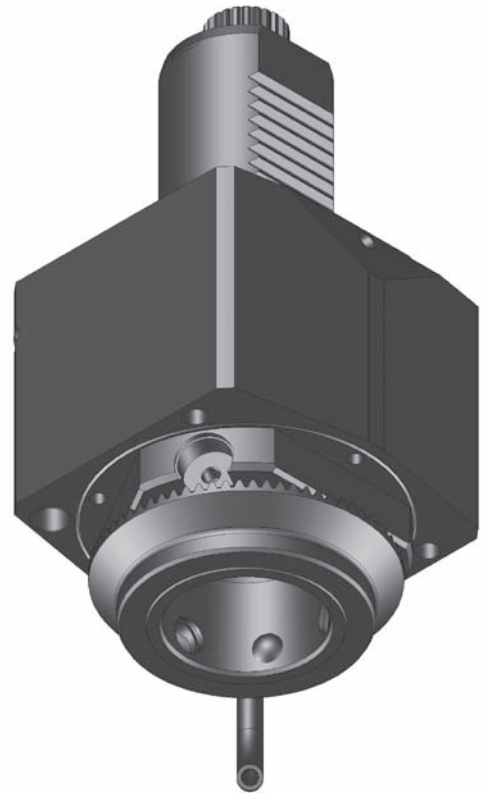
**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type      Star-type Turret  
Shank                VDI 40  
Drive                 DIN 5480  
                          with spindle orientation  
                          detent  
                          W 20x0,8x30x24 / 9b  
                          Ø 19,84 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	B mm	B1 mm	S mm	T mm	Rotating direction
133778	ER 32	1,0-20	80 Nm	6.500 / 6.500	i = 1:1	external	80	80	40	63	80	↺ ↻
133740	ER 32*	1,0-20	80 Nm	6.500 / 6.500	i = 1:1	internal	80	89	40	63	80	↺ ↻
133743	mi 50	0,5-20	80 Nm	6.500 / 6.500	i = 1:1	internal	92	84	42	63	84	↺ ↻
124161	HF 20	1,0-20	80 Nm	6.500 / 6.500	i = 1:1	internal	83	89	40	63	80	↺ ↻

# Angle Unit, Right-hand Version

for Turret Manufacturer

**SAUTER**

with Drive

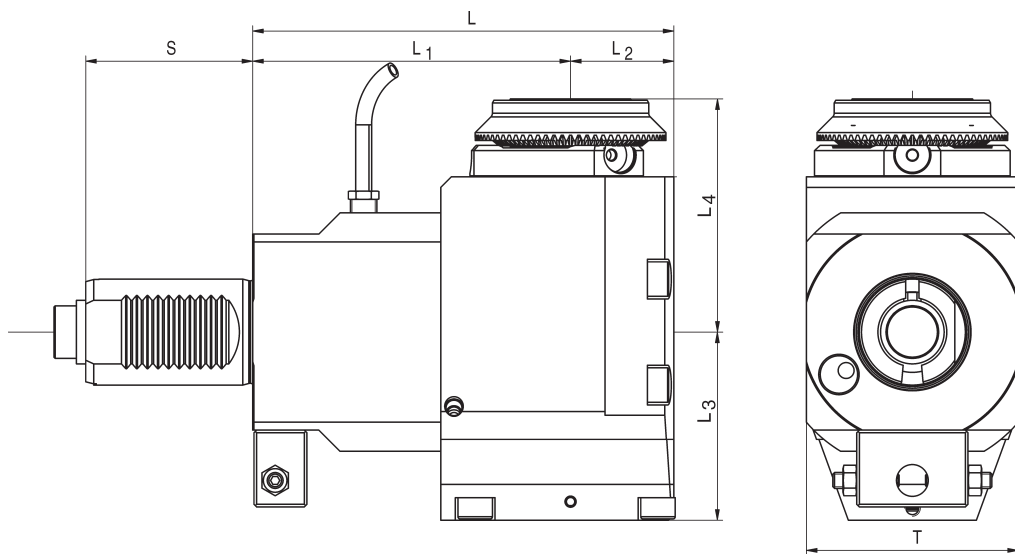
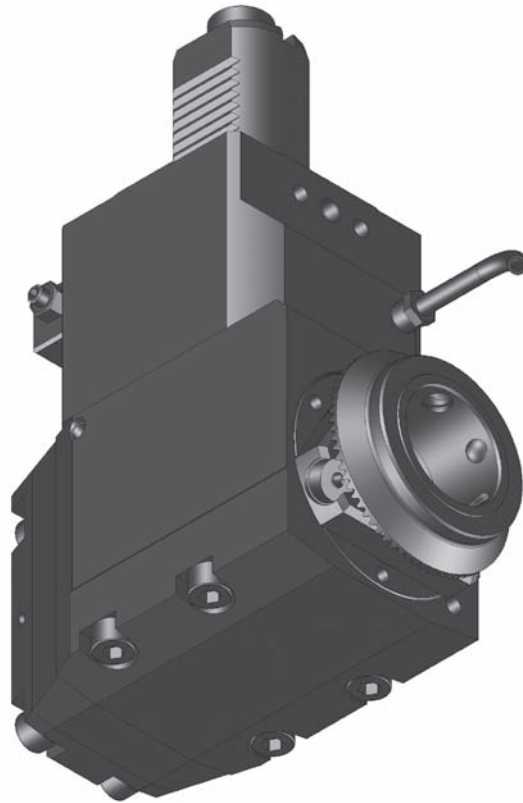
**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type      Star-type Turret  
Shank                VDI 40  
Drive                 DIN 5480  
                          with spindle orientation  
                          detent  
                          W 20x0,8x30x24 / 9b  
                          Ø 19,84 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
133765	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	139	100	39	69,0	70	63	85	↺ ↻
133780	ER 32*	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	internal	139	100	39	75,5	70	63	85	↺ ↻
133754	mi 50	-	80 Nm	5.400 / 5.400	i = 1:1	internal	139	100	43	75,5	88	63	80	↺ ↻
133748	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	159	120	39	69,0	70	63	85	↺ ↻
133773	ER 32*	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	internal	159	120	39	75,5	70	63	85	↺ ↻
133757	mi 50	-	80 Nm	5.400 / 5.400	i = 1:1	internal	163	120	43	75,5	88	63	80	↺ ↻
101568	ER 25*	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	159	120	39	72,5	75	63	85	↺ ↻
133802	HF 20	6,0-20	20 Nm	6.500 / 13.000	i = 1:2	internal	139	100	39	72,5	92	63	85	↺ ↻

\* With clamping nuts with sealing, seals see page 88

# Angle Unit, Left-hand Version

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

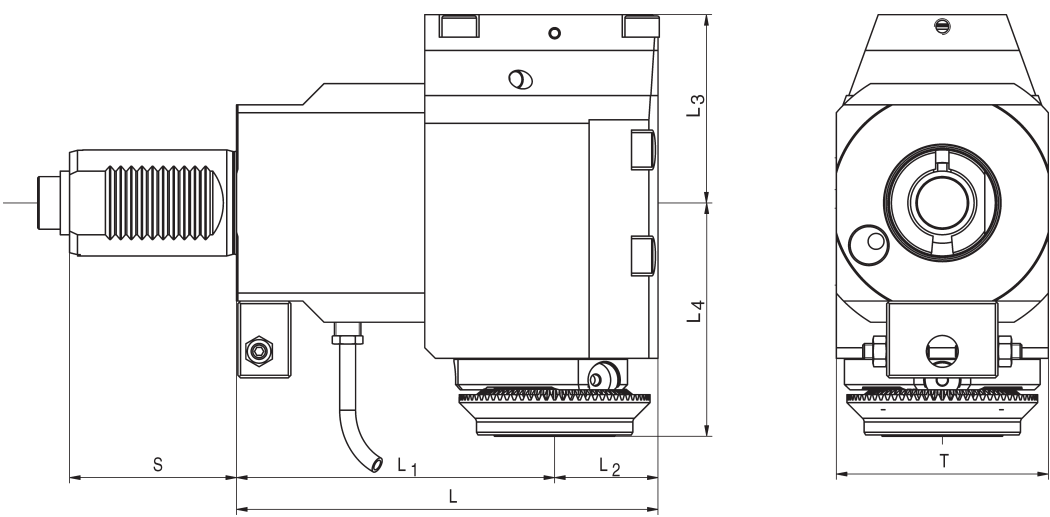
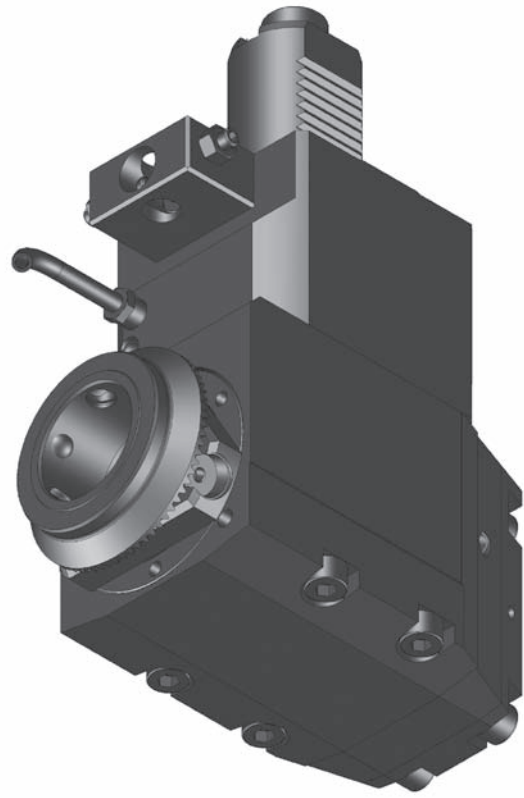
**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type      Star-type Turret  
Shank                VDI 40  
Drive                 DIN 5480  
                          with spindle orientation  
                          detent  
                          W 20x0,8x30x24 / 9b  
                          Ø 19,84 mm

Modular Interfaces

**mimaticMi**  
**HydroFLEX**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
133741	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	139	100	39	69,0	70	63	85	↺ ↻
133779	ER 32*	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	internal	139	100	39	75,5	70	63	85	↻ ↺
133744	mi 50	-	80 Nm	5.400 / 5.400	i = 1:1	internal	143	100	43	75,5	88	63	80	↻ ↺
133802	HF 20	6,0-20	20 Nm	6.500 / 13.000	i = 1:2	internal	139	100	39	72,5	92	63	85	↻ ↺
103561	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	159	120	39	69,0	70	63	85	↻ ↺
133776	ER 32*	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	internal	159	120	39	75,5	70	63	85	↻ ↺
133768	mi 50	-	80 Nm	5.400 / 5.400	i = 1:1	internal	163	120	43	75,5	88	63	80	↻ ↺
177075	ER 25	0,5-16	20 Nm	6.000 / 12.000	i = 1:2	internal	159	120	39	72,5	75	63	85	↻ ↺

# Angle Unit, Offset Type, Right-hand Version

for Turret Manufacturer



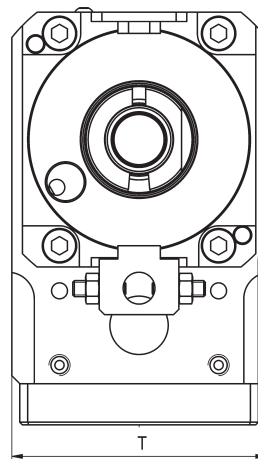
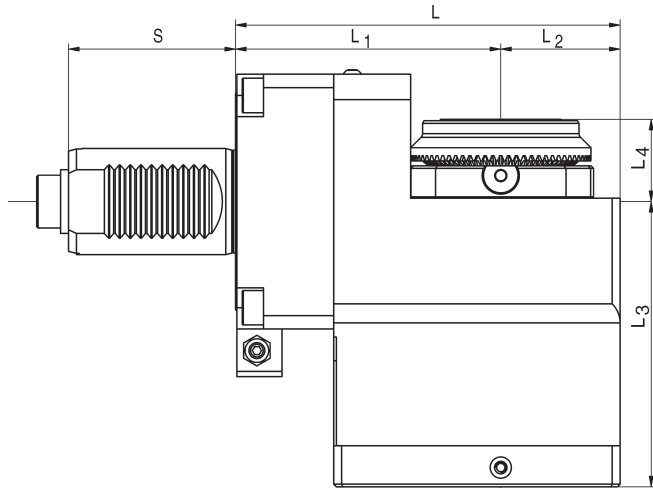
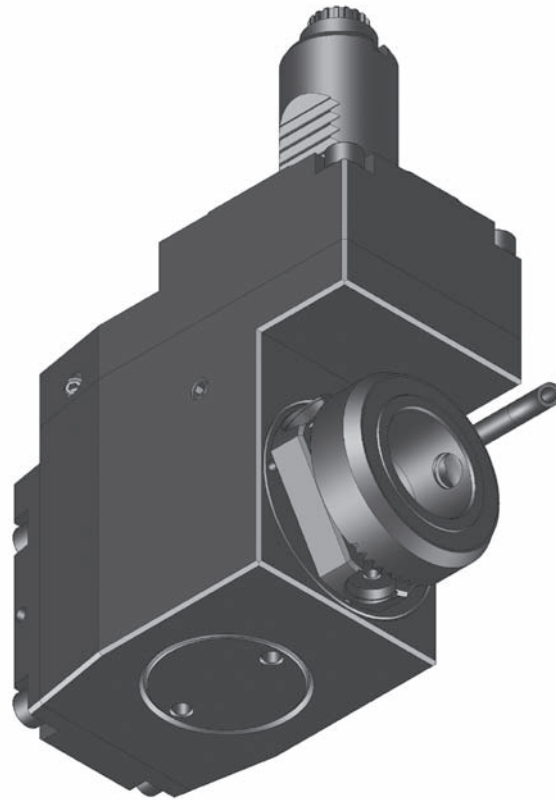
with Drive

**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type	Star-type Turret
Shank	VDI 40
Drive	DIN 5480 with spindle orientation detent W 20x0,8x30x24 / 9b Ø 19,84 mm

Modular Interfaces

Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
133759	ER 32	1,0-20	80 Nm	6.000 / 6.000	i = 1:1	external	142	100	42	111,0	20	63	85	↻ ↻
133774	ER 32*	1,0-20	80 Nm	6.000 / 6.000	i = 1:1	internal	142	100	42	111,0	20	63	85	↻ ↻
133782	mi 50	-	80 Nm	4.000 / 4.000	i = 1:1	internal	145	100	45	107,5	31	63	96	↻ ↻
103552	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	162	120	42	111,0	20	63	85	↻ ↻
103540	ER 32*	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	internal	162	120	42	111,0	20	63	85	↻ ↻
103553	mi 50	-	80 Nm	4.000 / 4.000	i = 1:1	internal	165	120	45	107,5	31	63	96	↻ ↻

\* With clamping nuts with sealing, seals see page 88

# Angle Unit, Offset Type, Left-hand Version

for Turret Manufacturer

**SAUTER**

with Drive

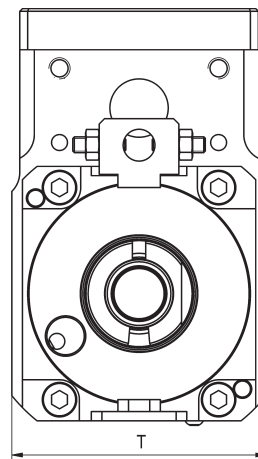
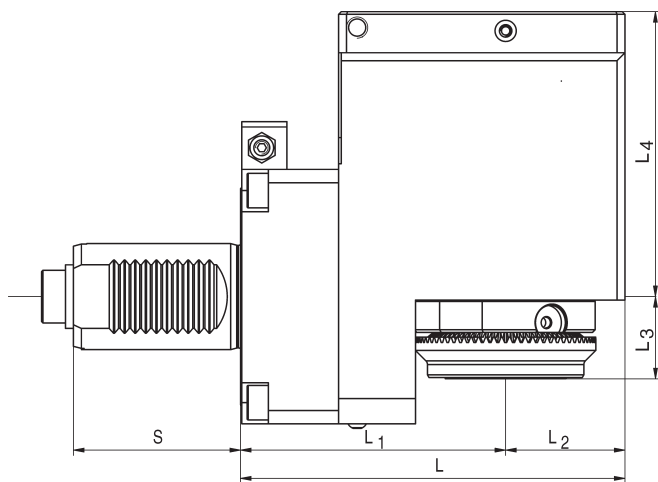
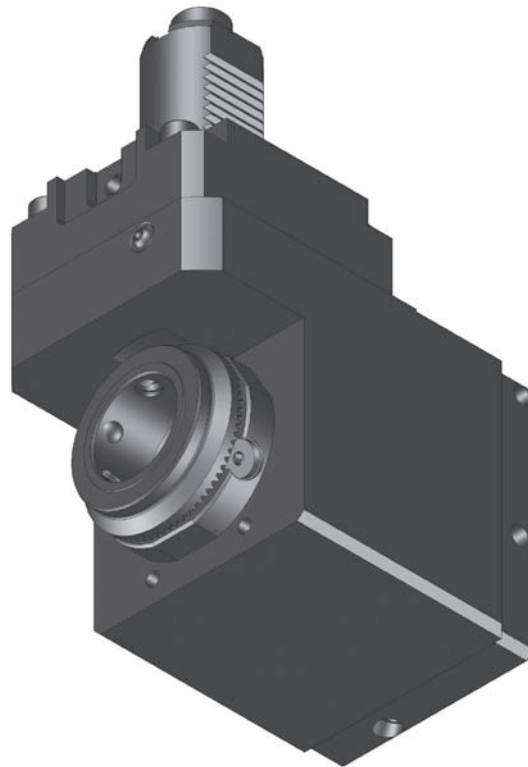
**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type	Star-type Turret
Shank	VDI 40
Drive	DIN 5480 with spindle orientation detent W 20x0,8x30x24 / 9b Ø 19,84 mm

Modular Interfaces

**mimaticMi**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm	Rotating direction
133781	ER 32	1,0-20	80 Nm	6.000 / 6.000	i = 1:1	external	142	100	42	111,0	20	63	85	↺ ↻
133758	ER 32*	1,0-20	80 Nm	6.000 / 6.000	i = 1:1	internal	142	100	42	111,0	20	63	85	↻ ↺
103572	mi 50	-	80 Nm	4.000 / 4.000	i = 1:1	internal	145	100	45	107,5	31	63	96	↻ ↺
103567	ER 32	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	external	162	120	42	111,0	20	63	85	↺ ↻
103548	ER 32*	1,0-20	80 Nm	5.400 / 5.400	i = 1:1	internal	162	120	42	111,0	20	63	85	↻ ↺
103584	mi 50	-	80 Nm	4.000 / 4.000	i = 1:1	internal	165	120	45	107,5	31	63	96	↻ ↺

# Angle Unit, 2-Axis

Connectable in accordance with **BLUECOMPETENCE** » mimatic mi » PolyMILL » TriMILL » TrioCut » PolyREAM

for Turret Manufacturer

**SAUTER**

with Drive

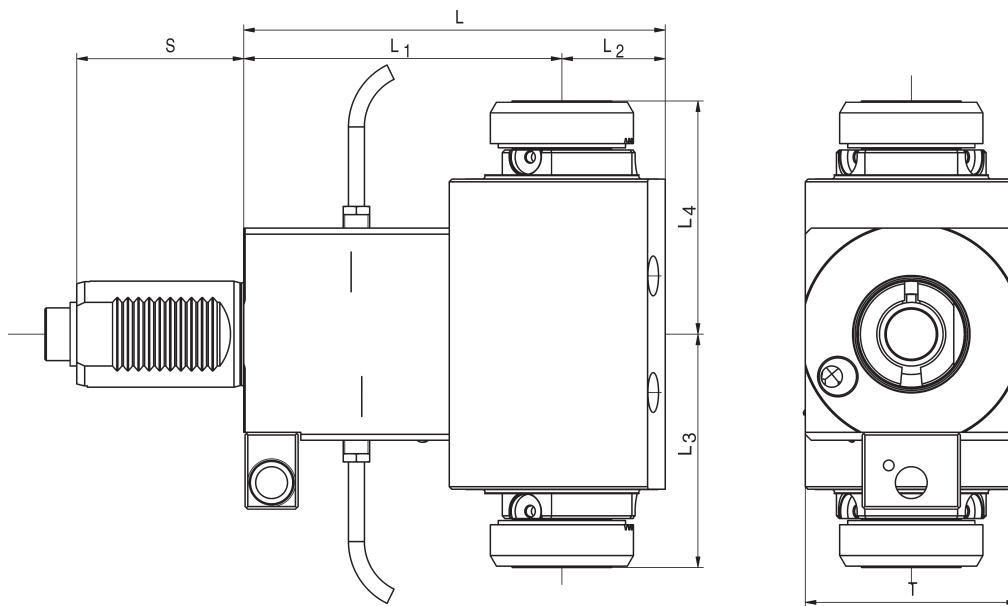
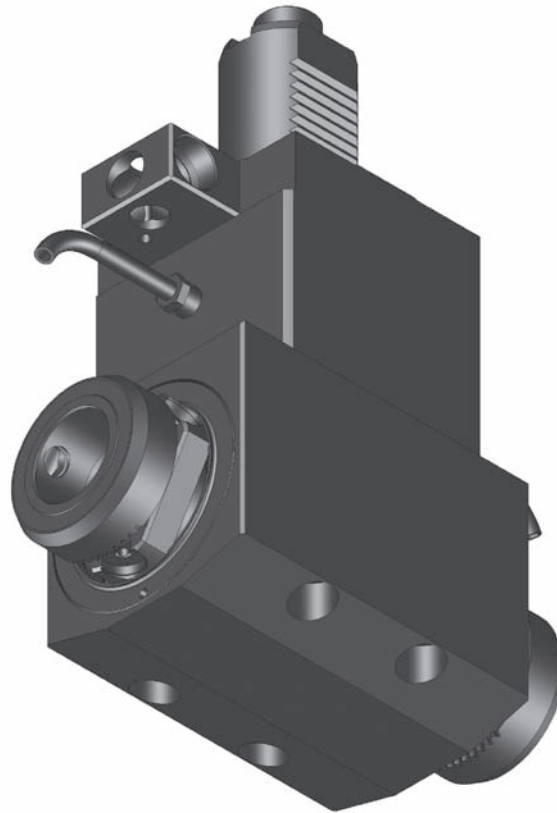
**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type      Star-type Turret  
Shank                VDI 40  
Drive                 DIN 5480  
                          with spindle orientation  
                          detent  
                          W 20x0,8x30x24 / 9b  
                          Ø 19,84 mm

Modular Interfaces

**mimaticMi**



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	S mm	T mm
103585	2x ER 25	0,5-16	20 Nm	6.500 / 6.500	i = 1:1	external	154	120	34	62	62	63	70
103593	2x mi 40	-	50 Nm	6.500 / 6.500	i = 1:1	external	154	120	34	88	88	63	70

# Angle Unit, Adjustable 0-100°

for Turret Manufacturer	
with Drive	
<b>DIN 5480</b> <b>(W 20 x 0,8 x 30 x 24 / 9b)</b>	
Dimensions	
Revolver type	Star-type Turret
Shank	VDI 40
Drive	DIN 5480 with spindle orientation detent W 20x0,8x30x24 / 9b Ø 19,84 mm

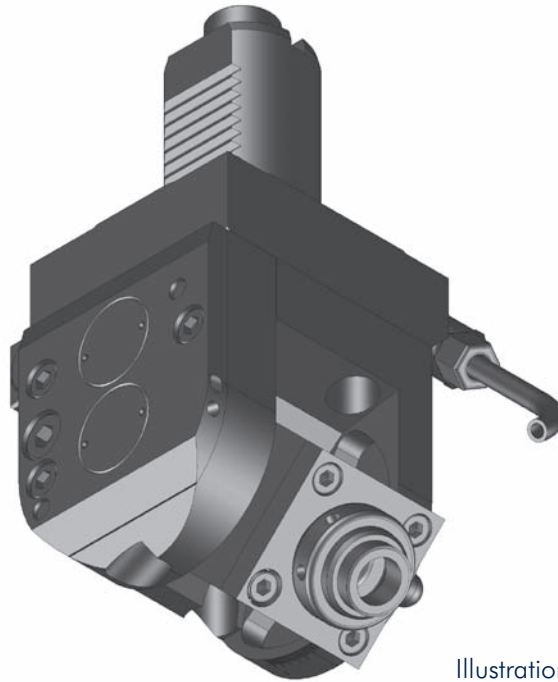
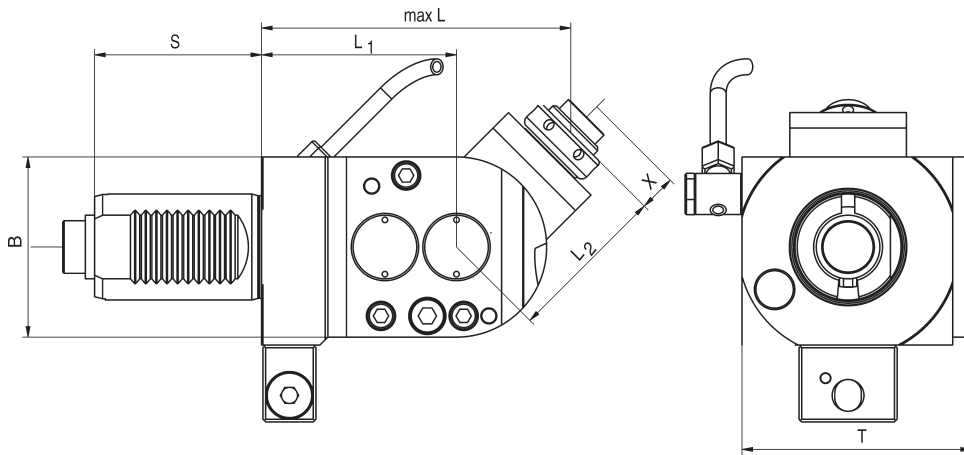


Illustration show  
right version



Order No.	Tool holder	Clamping range mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	B mm	S mm	T mm	Rotating direction
103541	ER 16	0,5-10	6 Nm	6.500 / 6.500	i = 1:1	external	134,5	73,5	61	68	63	80,5	
125010	ER 25	1,0-16	35 Nm	6.000 / 6.000	i = 1:1	external	178,0	88,0	93	102	63	96,0	



# Saw Blade Holder

for Turret Manufacturer

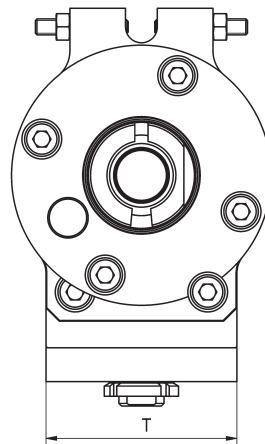
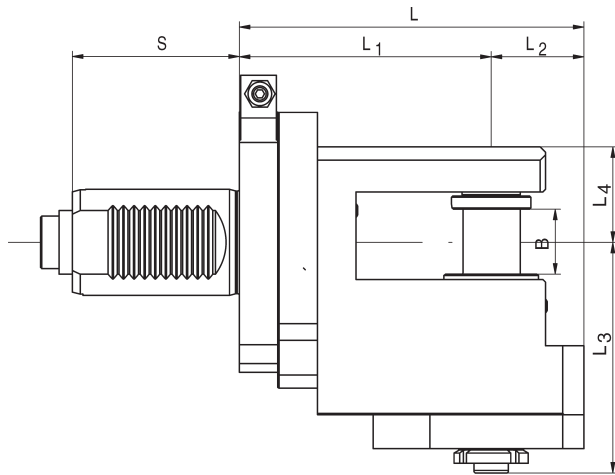
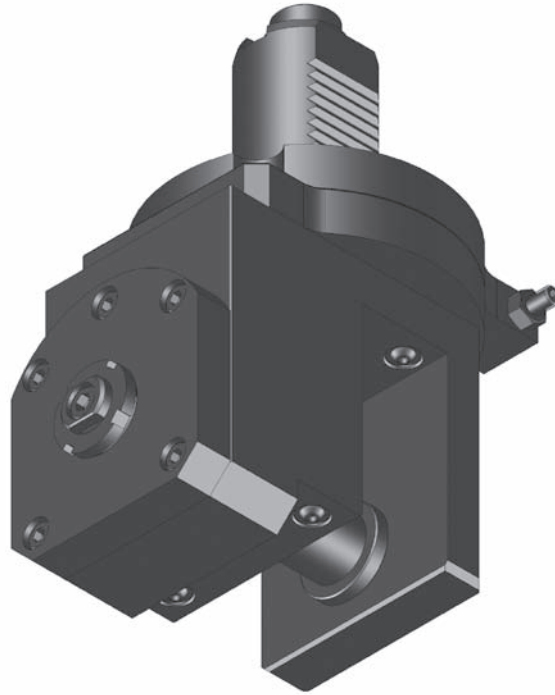
**SAUTER**

with Drive

**DIN 5480**  
**(W 20 x 0,8 x 30 x 24 / 9b)**

Dimensions

Revolver type	Star-type Turret
Shank	VDI 40
Drive	DIN 5480 with spindle orientation detent W 20x0,8x30x24 / 9b Ø 19,84 mm



Order No.	Fitting dia. mm	Torque max.	n1/n2 (max.) (r.p.m.)	Gear Ratio	Coolant	L mm	L1 mm	L2 mm	L3 mm	L4 mm	B mm	S mm	T mm
133749*	22	40 Nm	6.500 / 2.450	i = 2,66:1	external	130	95	35	87,5	36	25	63	72

\* Saw blade diameter max. = 100 mm

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<b>Combination Shell End Mill Arbors</b> 	Ø 16-27 mm		63
<b>Weldon Toolholders</b> <b>Whistle-Notch Toolholders</b> 	Ø 6-25 mm Ø 1/4"-1/0"	DIN 1835 B DIN 1835 B	64 64
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## Advantages

- Universal tool clamping system for all production areas
- Presetting of the tools off-line by length adjustment screw
- Tool change within seconds
- Concentricity of the interface < 0,002 mm
- Secure holding force by form-locking
- Very short design
- Toolholders in different sizes
- All toolholders with internal coolant

## Use on CNC-Turning Machines and Machining Centers

Driven toolholders for all turning machines, machining centers, milling machines, turn/mill centers as well as transfer and special machines. Driven toolholders / basic holders are available in many different versions:

- Shafts such as VDI, SK, BT, CAT, HSK, Capto, ...
- Straight and angle units
- Single or multi-spindle versions
- Gear multiplication or reduction
- Internal and/or external coolant supply
- Central or offset

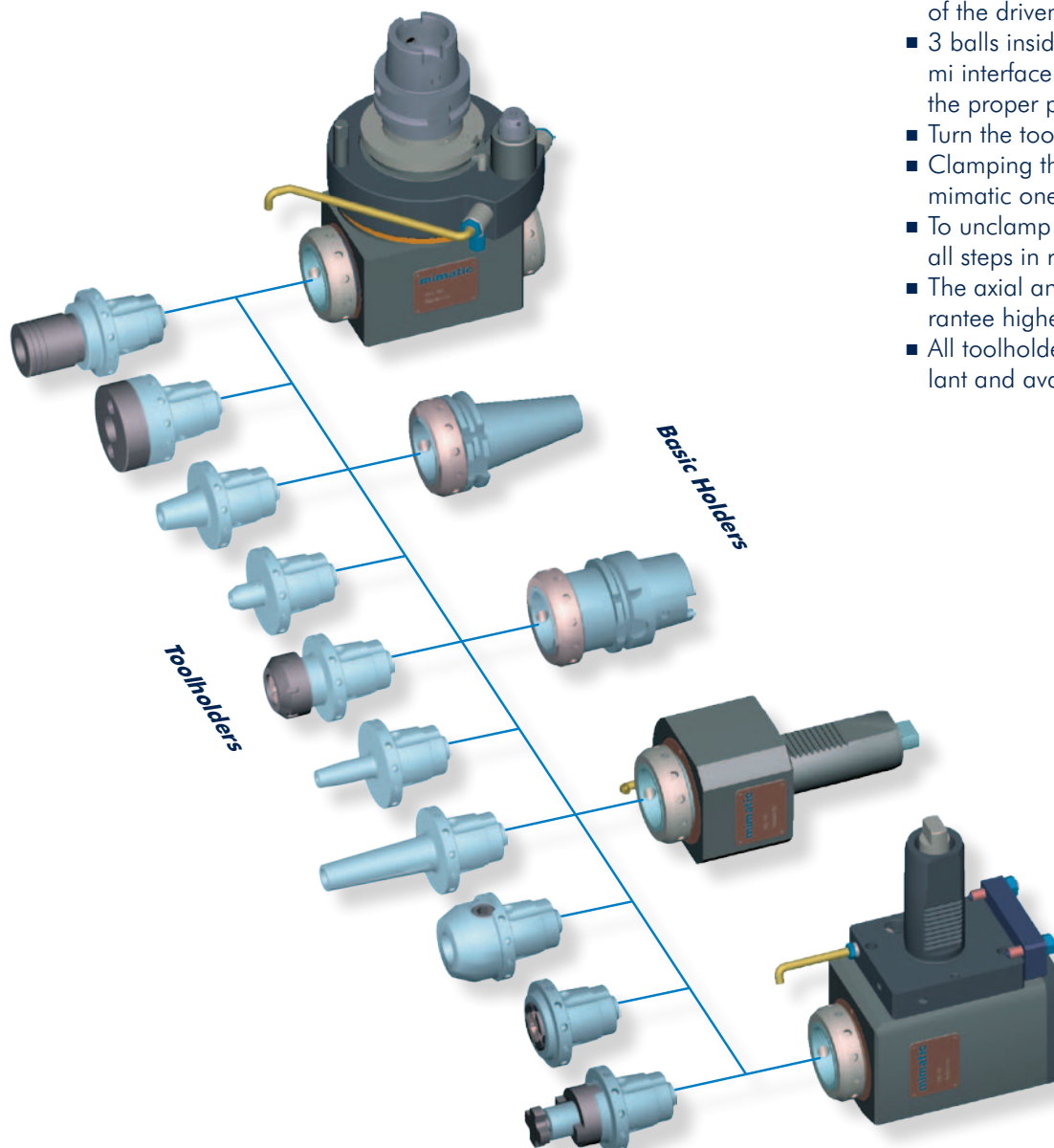
## Modular Toolholders in Different Sizes for All Production Areas

- Tapping toolholders
- Collet toolholders (internal and external nut)
- Hydro-Flex hydraulic toolholders
- Thread tightening toolholder cutters
- Morse taper shank toolholders
- Weldon and Whistle Notch toolholders
- Shell mill toolholders

All toolholders are available for use with your presetter.

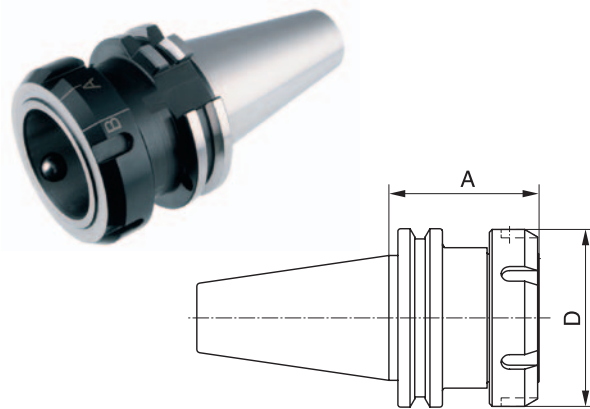
## mi Operation

- Insert the toolholder into the spindle of the driven toolholder
- 3 balls inside the modular mimatic mi interface guide the toolholder into the proper position
- Turn the toolholder until it is locked
- Clamping the sleeve nut by using the mimatic one hand key
- To unclamp the toolholder just follow all steps in reverse order
- The axial and conical surface guarantee highest concentricity
- All toolholders are with internal coolant and available in different sizes



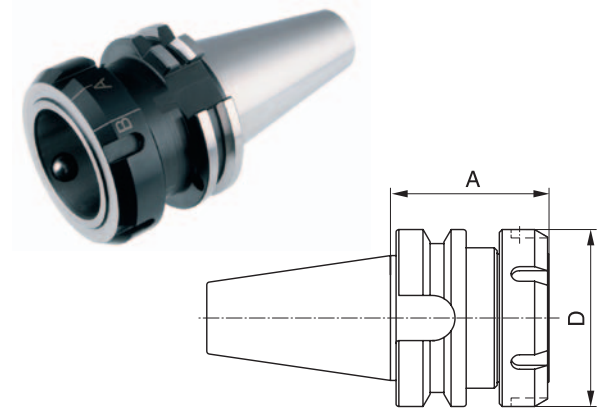
## Basic Holders

### DIN 69871 AD/B



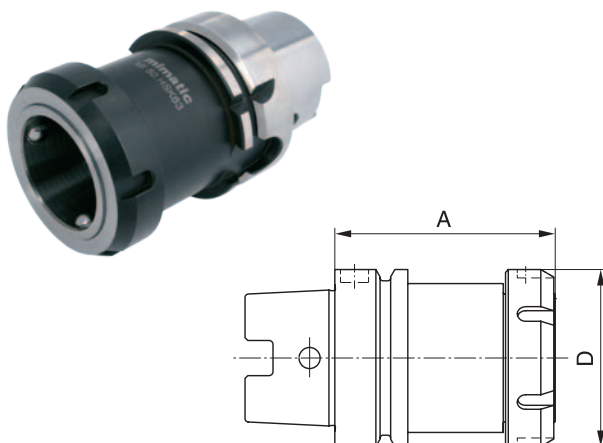
Order No.	Size	SK	A mm	D mm
121454	mi 32	SK 30	53,5	45
155404	mi 40	SK 40	53,5	54
155502	mi 50	SK 40	53,5	63
155481	mi 50	SK 50	53,5	63
155477	mi 63	SK 50	58,5	77

### MAS-BT JIS 6339



Order No.	Size	BT	A mm	D mm
121481	mi 32	BT 30	45,0	45
121512	mi 40	BT 40	48,5	54
155469	mi 50	BT 40	56,5	63
155457	mi 50	BT 50	61,5	63
121552	mi 63	BT 50	70,0	77

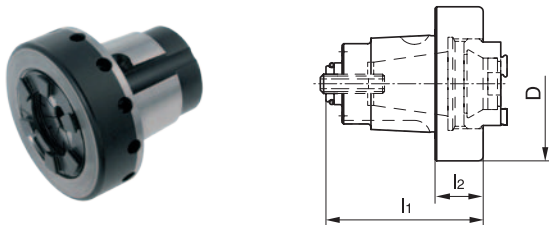
### DIN 69893 A



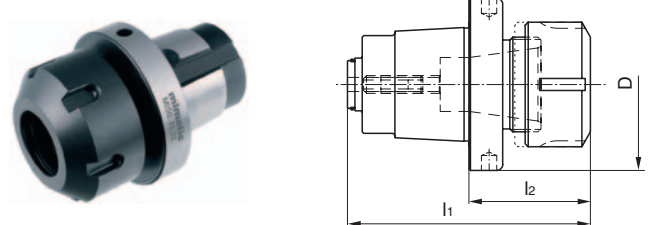
Order No.	Size	HSK	A mm	D mm
155410	mi 40	HSK 50	60,0	54
155458	mi 50	HSK 63	78,5	63
121562	mi 50	HSK 100	85,0	63
121577	mi 63	HSK 100	100,0	77

## Collet Chucks DIN 6499 – Type ER

- short type
- clamping nut inside
- with internal coolant



- long type
- clamping nut outside
- with internal coolant

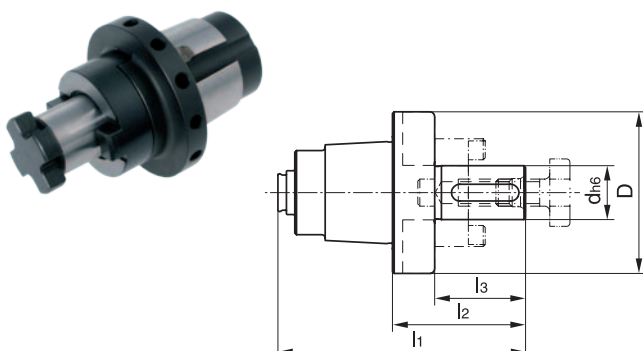


Order No.	Size	Collet	l1 mm	l2 mm	D mm
121479	mi 32	ER 11	41,5	15	42
155357	mi 32	ER 16	41,5	15	42
171839	mi 32	ER 20	59,0	32	36
155388	mi 40	ER 16	45,0	11	48
155335	mi 40	ER 20	49,0	15	48
155367	mi 40	ER 25	55,0	21	48
155418	mi 50	ER 25	55,0	14	58
155460	mi 50	ER 32	59,0	18	58
155471	mi 63	ER 32	63,0	14	75
155496	mi 63	ER 40	69,0	20	75

Order No.	Size	Collet	l1 mm	l2 mm	D mm
155358	mi 32	ER 11	72,5	46,0	42
155319	mi 32	ER 16	64,5	38,0	42
121460	mi 40	ER 16	73,0	39,0	48
121502	mi 40	ER 20	80,0	46,6	48
155448	mi 50	ER 25	82,0	41,0	58
155445	mi 50	ER 32	88,0	47,0	58
155475	mi 63	ER 32	96,0	47,0	75
155451	mi 63	ER 40	94,5	45,5	75

## Combination Shell End Mill Arbor

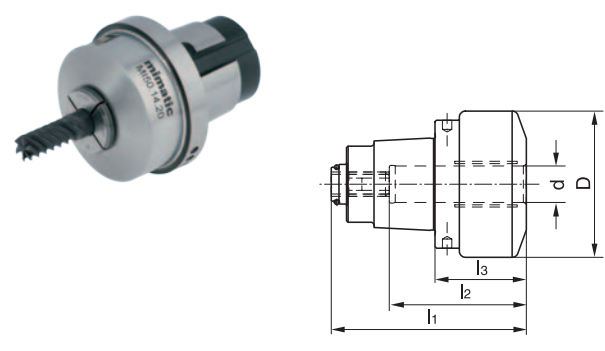
without internal coolant



Order No.	Size	l1 mm	l2 mm	l3 mm	d h6 mm	D mm
121486	mi 32	66,0	39,5	27	16	42
155365	mi 40	73,5	39,5	25	16	48
155447	mi 50	82,0	41,0	27	16	58
155413	mi 50	88,0	47,0	31	22	58
155512	mi 63	96,0	47,0	31	22	75
155465	mi 63	98,0	49,0	33	27	75

## Hydraulic Chuck

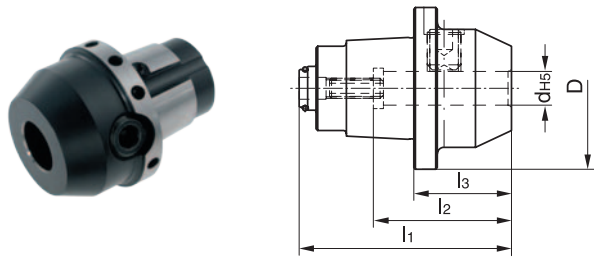
with internal coolant



Order No.	Size	l1 mm	l2 mm	l3 mm	d h6 mm	D mm
155391	mi 40	64	45	30	12	48
155417	mi 50	71	52	30	20	58

## Weldon Toolholder DIN 1835 B

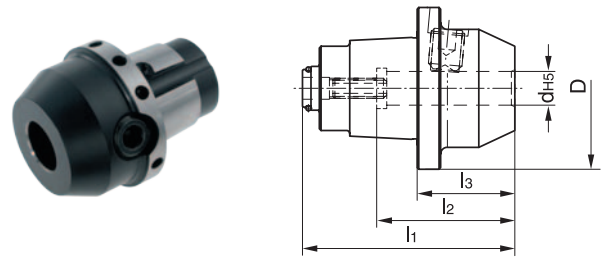
with internal coolant



Order No.	Size	l1 mm	l2 mm	l3 mm	d H5 mm / "	D mm
121436	mi 32	52,5	37	26,0	6	42
121478	mi 32	52,5	37	26,0	8	42
121469	mi 32	55,5	41	29,0	10	42
121439	mi 32	57,5	46	31,0	12	42
121449	mi 32	52,5	37	26,0	1/4"	42
121472	mi 32	55,5	41	29,0	3/8"	42
121448	mi 32	57,5	46	31,0	1/2"	42
155330	mi 40	60,0	37	26,0	6	48
155346	mi 40	60,0	37	26,0	8	48
155321	mi 40	63,0	41	29,0	10	48
155331	mi 40	65,0	46	31,0	12	48
155326	mi 40	65,0	46	31,0	14	48
155379	mi 40	68,0	49	34,0	16	48
121497	mi 40	60,0	37	26,0	1/4"	48
121475	mi 40	63,0	41	29,0	3/8"	48
121474	mi 40	65,0	46	31,0	1/2"	48
121499	mi 40	68,0	49	34,0	5/8"	48
155419	mi 50	65,0	37	24,0	6	58
155411	mi 50	66,0	37	25,0	8	58
155400	mi 50	70,0	41	29,0	10	58
155406	mi 50	73,0	46	32,0	12	58
155412	mi 50	73,0	46	32,0	14	58
155407	mi 50	74,0	49	33,0	16	58
155427	mi 50	78,0	51	37,0	20	58
121489	mi 50	65,0	37	24,0	1/4"	58
121529	mi 50	40,0	41	29,0	3/8"	58
121525	mi 50	73,0	46	32,0	1/2"	58
121520	mi 50	75,0	49	34,0	5/8"	58
121526	mi 50	78,0	51	37,0	3/4"	58
155470	mi 63	81,0	37	32,0	6	75
155459	mi 63	82,0	37	33,0	8	75
155490	mi 63	85,0	41	36,0	10	75
155509	mi 63	88,5	46	39,5	12	75
155463	mi 63	88,5	46	39,5	14	75
155482	mi 63	91,0	49	42,0	16	75
155474	mi 63	93,0	51	44,0	20	75
155464	mi 63	110	59	61,0	25	75
166815	mi 63	81,0	37	32,0	1/4"	75
166805	mi 63	85,0	41	36,0	3/8"	75
166813	mi 63	88,5	46	39,5	1/2"	75
166807	mi 63	91,0	49	42,0	5/8"	75
166804	mi 63	93,0	51	44,0	3/4"	75
166812	mi 63	110	59	61,0	1/0"	75

## Whistle Notch Toolholder DIN 1835 E

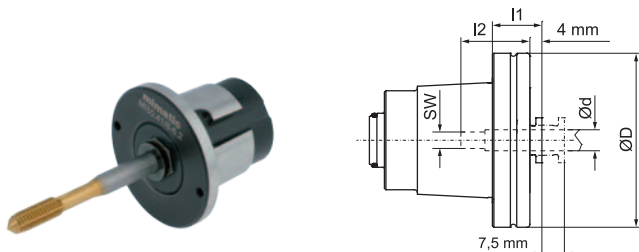
with internal coolant



Order No.	Size	l1 mm	l2 mm	l3 mm	d H5 mm / "	D mm
121463	mi 32	52,5	36	26,0	6	42
121464	mi 32	52,5	36	26,0	8	42
121443	mi 32	55,5	40	29,0	10	42
121453	mi 32	57,5	45	31,0	12	42
121442	mi 32	52,5	36	26,0	1/4"	42
121485	mi 32	55,5	40	29,0	3/8"	42
121480	mi 32	57,5	45	31,0	1/2"	42
155369	mi 40	60,0	36	26,0	6	48
155363	mi 40	60,0	36	26,0	8	48
155370	mi 40	63,0	40	29,0	10	48
155364	mi 40	65,0	45	31,0	12	48
155333	mi 40	65,0	45	31,0	14	48
155382	mi 40	68,0	48	34,0	16	48
121492	mi 40	60,0	36	26,0	1/4"	48
121493	mi 40	63,0	40	29,0	3/8"	48
121455	mi 40	65,0	45	31,0	1/2"	48
121494	mi 40	68,0	48	34,0	5/8"	48
169197	mi 40	89,0	50	55,0	20	52
155416	mi 50	65,0	36	24,0	6	58
155401	mi 50	66,0	36	25,0	8	58
155383	mi 50	70,0	40	29,0	10	58
155408	mi 50	73,0	45	32,0	12	58
155435	mi 50	73,0	45	32,0	14	58
155436	mi 50	75,5	48	34,5	16	58
155384	mi 50	78,0	50	37,0	20	58
166816	mi 50	65,0	36	24,0	1/4"	58
155440	mi 50	70,0	40	29,0	3/8"	58
155434	mi 50	73,0	45	32,0	1/2"	58
155428	mi 50	75,0	48	34,0	5/8"	58
155385	mi 50	78,0	50	37,0	3/4"	58
166104	mi 63	81,0	36	32,0	6	75
166105	mi 63	82,0	36	33,0	8	75
166110	mi 63	85,0	40	36,0	10	75
166112	mi 63	88,5	45	39,5	12	75
166113	mi 63	88,5	45	39,5	14	75
166114	mi 63	91,0	48	42,0	16	75
166115	mi 63	93,0	50	44,0	20	75
166116	mi 63	110	56	61,0	25	75
166797	mi 63	81,0	36	32,0	1/4"	75
166799	mi 63	85,0	40	36,0	3/8"	75
166796	mi 63	88,5	45	39,5	1/2"	75
166803	mi 63	91,0	48	42,0	5/8"	75
166798	mi 63	93,0	50	44,0	3/4"	75
166795	mi 63	110	56	61,0	1/0"	75

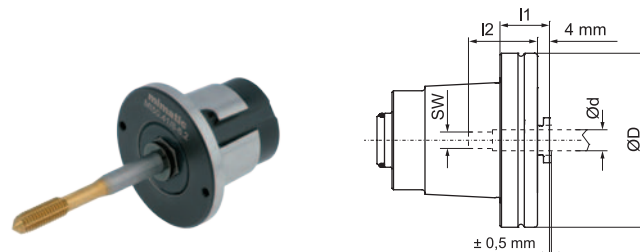
## SYNAX® Tapping Quick Change Holder

without internal coolant,  
with synchronisation and length compensation



Order No.	Size	l1 mm	l2 mm	d mm	D mm	SW
121510	mi 40	17,0	25	3,5	48	2,7
155397	mi 40	17,0	25	4,5	48	3,4
155377	mi 40	17,0	27	6,0	48	4,9
155378	mi 40	17,0	27	8,0	48	6,2
155403	mi 40	38,0	28	9,0	48	7,0
121451	mi 40	38,0	29	10,0	48	8,0
121498	mi 40	38,0	30	12,0	48	9,0
155450	mi 50	16,5	25	3,5	58	2,7
155487	mi 50	16,5	25	4,5	58	3,4
155422	mi 50	16,5	27	6,0	58	4,9
155497	mi 50	16,5	27	7,0	58	5,5
155455	mi 50	16,5	27	8,0	58	6,2
155423	mi 50	16,5	28	9,0	58	7,0
155466	mi 50	16,5	29	10,0	58	8,0
155472	mi 50	44,0	36	11,0	58	9,0
155449	mi 50	16,5	30	12,0	58	9,0
155479	mi 50	44,0	33	16,0	58	12,0

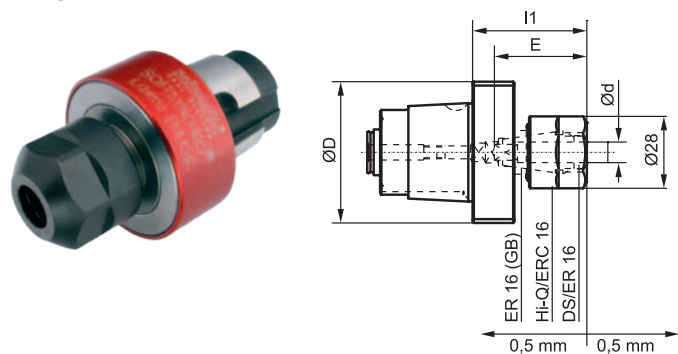
with internal coolant (70 bar),  
only synchronisation



Order No.	Size	l1 mm	l2 mm	d mm	D mm	SW
155389	mi 40	17,0	27	6	48	4,9
121522	mi 40	17,0	27	8	48	6,2
121515	mi 40	38,0	28	9	48	7,0
121504	mi 40	38,0	29	10	48	8,0
121517	mi 40	38,0	30	12	48	9,0
155432	mi 50	16,5	27	6	58	4,9
172720	mi 50	16,5	27	7	58	5,5
155498	mi 50	16,5	27	8	58	6,2
155473	mi 50	16,5	28	9	58	7,0
155467	mi 50	16,5	29	10	58	8,0
155446	mi 50	16,5	30	12	58	9,0
121534	mi 50	44,0	33	16	58	12,0

## Softsynchro Chuck (Licence Emuge)

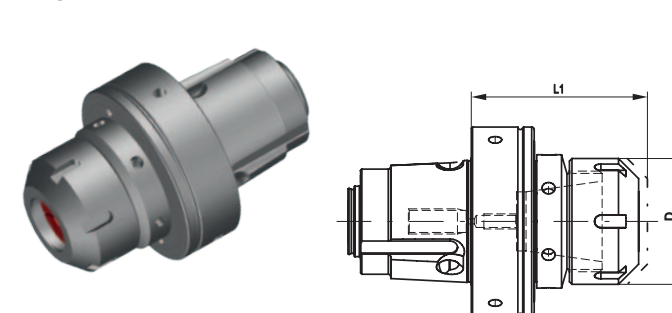
with internal coolant,  
with push and pull length  
compensation 0,5 mm



Order No.	Size	Collet	Thread	l1 mm	d mm	D mm
121503	mi 40	ER-GB 16	M4-M12	47,5	4,5-10	45
121530	mi 50	ER-GB 16	M4-M12	44,5	4,5-10	50

## Chuck for GB Collets

with internal coolant,  
with push and pull length  
compensation ±0,5 mm

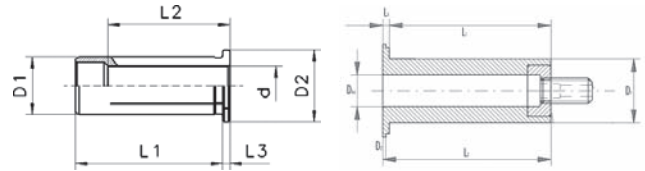


Order No.	Size	Collet	L1 mm	D mm
121518	mi 40	ER 20 GB(1-13)	60	28
155488	mi 50	ER 25 GB(1-16)	60	42
155491	mi 63	ER 32 GB(2-20)	70	50



## Accessory for Hydraulic Chucks

### Sleeve



without horizontal adjustment

with horizontal adjustment

Order No.	D1 mm	d h6 mm / "	L1 mm	L2 mm	L3 mm	D2 mm
119790	12	3	40	29	4	16
119793	12	1/8"	40	29	4	16
119797	12	4	40	29	4	16
119798	12	3/16"	40	29	4	16
119819	12	5	40	29	4	16
119812	12	6	40	36	4	16
119813	12	1/4"	40	36	4	16
119791	12	7	40	37	4	16
119799	12	5/16"	40	37	4	16
119810	12	8	40	37	4	16
119792	12	9	40	37	4	16
119815	12	3/8"	40	40	4	16
119814	12	10	40	40	4	16
119816	20	3	50	28	4	25
119823	20	1/8"	50	28	4	25
119817	20	4	50	28	4	25
119837	20	3/16"	50	28	4	25
119800	20	5	50	28	4	25
119801	20	6	50	36	4	25
119822	20	1/4"	50	36	4	25
119818	20	7	50	38	4	25
119839	20	5/16"	50	37	4	25
119820	20	8	50	37	4	25
119802	20	9	50	38	4	25
119838	20	3/8"	50	38	4	25
119824	20	10	50	40	4	25
119825	20	11	50	40	4	25
119830	20	7/16"	50	45	4	25
119826	20	12	50	45	4	25
119821	20	1/2"	50	45	4	25
119827	20	14	50	45	4	25
119846	20	9/16"	50	45	4	25
119829	20	5/8"	50	48	4	25
119828	20	16	50	48	4	25
119847	25	3	56	29	4	30
119848	25	4	56	29	4	30
119831	25	5	56	29	4	30
119849	25	6	56	37	4	30
119832	25	7	56	37	4	30
119833	25	8	56	37	4	30
119834	25	9	56	38	4	30
119850	25	10	56	40	4	30
119835	25	12	56	46	4	30
119851	25	14	56	47	4	30
119836	25	16	56	48	4	30
119841	25	18	56	48	4	30
119842	25	20	56	50	4	30
119844	32	6	60	36	4	36

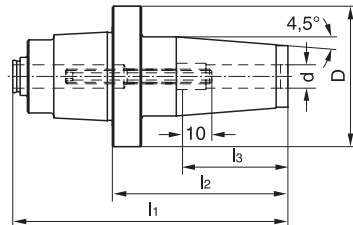
Order No.	D1 mm	d h6 mm / "	L1 mm	L2 mm	L3 mm	D2 mm
119857	32	1/4"	60	36	4	36
119845	32	7	60	37	4	36
119879	32	5/16"	60	36	4	36
119852	32	8	60	36	4	36
119855	32	9	60	37	4	36
119884	32	3/8"	60	37	4	36
119864	32	10	60	40	4	36
119853	32	11	60	40	4	36
119858	32	12	60	45	4	36
119856	32	1/2"	60	45	4	36
119859	32	13/16"	60	45	4	36
119865	32	14	60	46	4	36
119854	32	15/16"	60	46	4	36
119861	32	5/8"	60	46	4	36
119866	32	16	60	48	4	36
119870	32	18	60	49	4	36
119878	32	3/4"	60	50	4	36
119877	32	20	60	50	4	36
119867	32	25	60	56	4	36

### with horizontal adjustment

119909	20	6	50	52	-	28
119889	20	8	50	52	-	28
152696	20	10	50	52	-	28
119910	20	12	50	52	-	28
119901	20	14	50	52	-	28
119911	20	16	50	52	-	28
119892	20	18	50	52	-	28
119893	25	10	56	59	-	32
119912	25	12	56	59	-	32
119894	25	14	56	59	-	32
119895	25	16	56	59	-	32
167144	25	18	56	59	-	32
167045	25	20	56	59	-	32

## Shrink fit Chuck

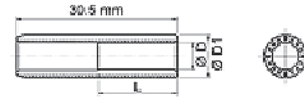
with internal coolant



Order No.	Size	l1 mm	l2 mm	l3 mm	d h6 mm	D mm
155381	mi 40	94	60	36	8	48
121482	mi 40	94	60	42	10	48
155334	mi 40	99	65	47	12	48
121501	mi 40	104	70	50	16	48
155421	mi 50	101	60	36	8	58
155409	mi 50	101	60	42	10	58
155444	mi 50	106	65	47	12	58
155438	mi 50	106	65	47	14	58
155430	mi 50	111	70	50	16	58
155431	mi 50	116	75	50	18	58
155454	mi 50	116	75	52	20	58

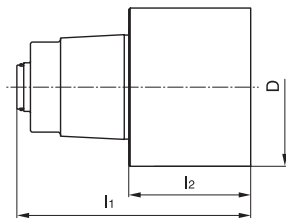
## Accessory for Shrink fit Chucks

Sleeve



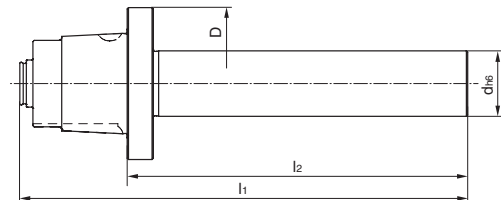
Order No.	L mm	L1 mm	d h6 mm	D mm
119807	30,5	7,5	2,5	8
119787	30,5	9,0	3,0	8
119808	30,5	10,5	3,5	8
119809	30,5	12,0	4,0	8
119788	30,5	13,5	4,5	8
119789	30,5	15,0	5,0	8
119796	30,5	16,5	5,5	8

## Blank



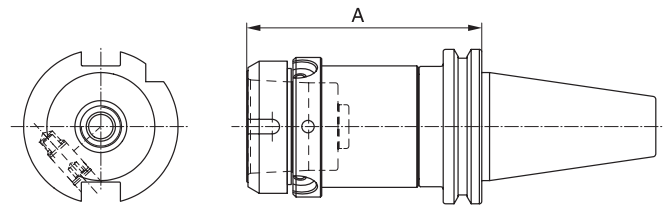
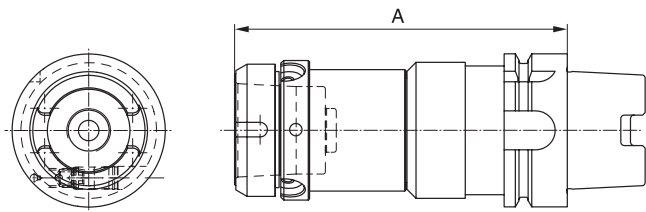
Order No.	Size	l1 mm	l2 mm	D mm
121457	mi 32	76,5	50	42
166791	mi 40	94,0	60	48
166789	mi 50	111,0	70	58
121557	mi 63	129,0	80	75

## Test Mandrel



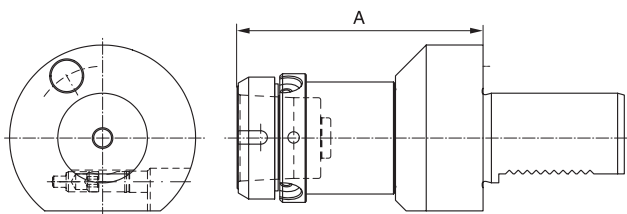
Order No.	Size	l1 mm	l2 mm	d h6 mm	D mm
170569	mi 25		110		14
172991	mi 32		110		18
156208	mi 40		130		20
156082	mi 50		130		25
172992	mi 63		150		32

## Tool Presetting Unit



Order No.	Size	HSK	A mm
171098	mi 25	63	130,0
155352	mi 32	63	130,0
155380	mi 40	63	134,5
173224	mi 40	100	143,0
155429	mi 50	63	136,9
168301	mi 50	100	143,0
166990	mi 63	63	147,0
169267	mi 63	100	155,0

Order No.	Size	SK	A mm
121471	mi 40	40	95
121491	mi 40	50	128
155405	mi 50	40	97
121527	mi 50	50	140
155504	mi 63	50	140



Order No.	Size	VDI	A mm
155368	mi 40	40	108
155356	mi 50	40	110
155372	mi 40	50	108
121524	mi 50	50	110

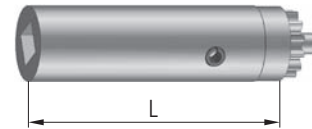
## Accessories for mi-system

### Complete Wrench for One-hand Operation



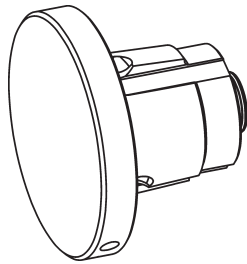
Order No.	Size
170734	mi 25, mi 32, mi 40
170419	mi 50, mi 63

### Socket Wrench for Torque Wrench



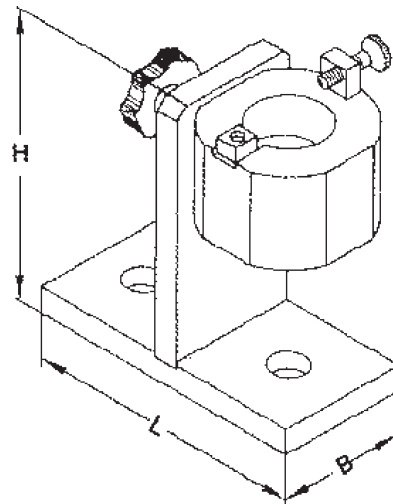
Order No.	Size	L mm	Wrench size
173988	mi 25, mi 32, mi 40	50	1/4"
173985	mi 50, mi 63	50	1/4"

### Protection Plug



Order No.	Size
174460	mi 32
174458	mi 40
174457	mi 50
174459	mi 63

### Assembling Jig



Order No.	Size	L mm	B mm	H mm
166774	SK 40	130	64	136
166775	HSK 63	130	64	136
121571	VDI 40	130	64	136

# mimatic mi – An Epitome of BlueCompetence

**BLUECOMPETENCE**

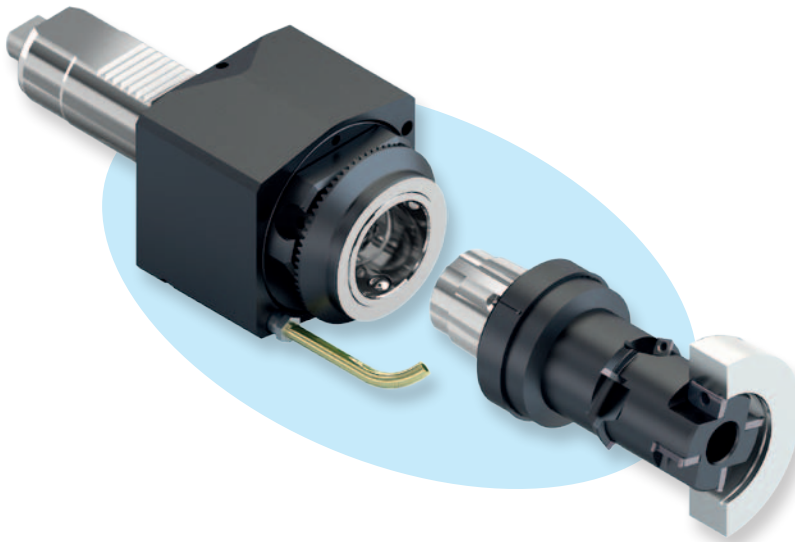
Alliance Member

Partner of the Engineering Industry Sustainability Initiative

## mimatic® Tool Systems for Sustainability and Efficiency

Tools according to the policy of BLUECOMPETENCE are marked in this catalogue. More information on the program (Initiative) of the VDMA see pages 16-17.

## mi – The Integrated Tool Solution = Driven Tool Holder + mi Interface + mi Tool



### Advantages

#### mi – Interface, Driven Tool Sided

- short taper + planar arrangement
- shorter construction
- convenient single-hand operation
- symmetrical 3-point intake

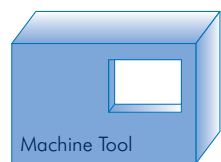
#### mi – Fast Change

- in the machine
- minimal tool changing time
- no pre-adjustment necessary

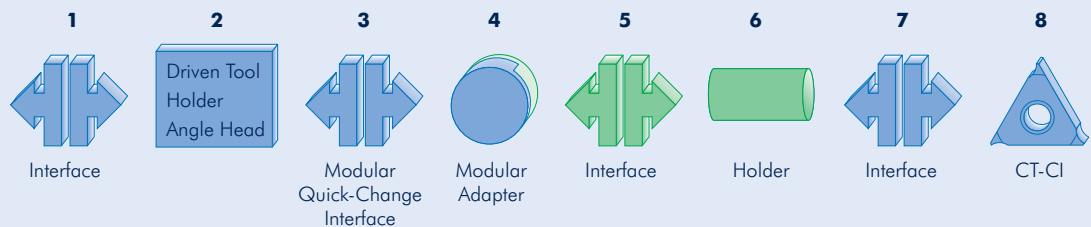
#### mi – Chipping Tool

- compact – one-piece design
- milling, counterboring, planing, chamfering
- shells, shaft, ...

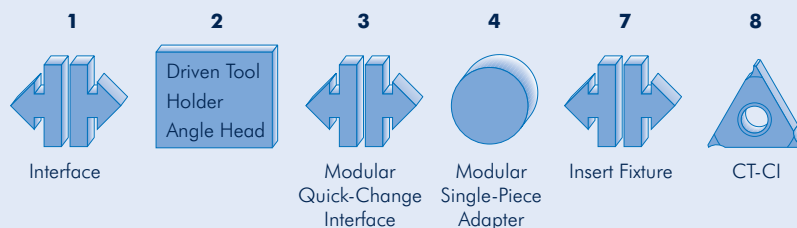
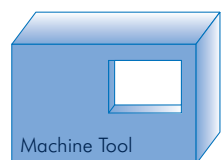
## BlueCompetence – Implemented with mimatic mi



### Old = Industrial Standard



### New = mimatic Innovation



# mi System Solutions for Special Production Assignments

**Driven tool holders with mi quick-change interface must be adapted to the machining task in your dimensioning, and/or take this task into account:**

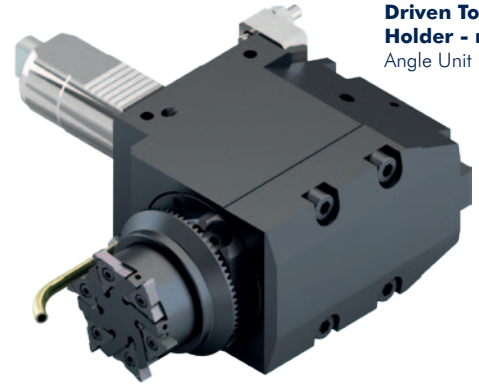
- as regards the cutting forces and/or torque occurring and
- as regards the precision required » rigidity of the system

It is thus necessary to describe the planned machining processes as exactly as possible, so that the optimal technical and economic suggestion can be worked out. Because then it is ensured that the requirements for precision, efficiency and sustainability are fulfilled.

**Driven Tool Holder - mi**  
Straight Unit

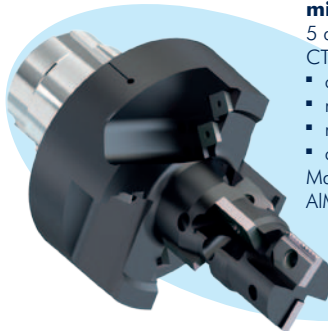


**Driven Tool Holder - mi**  
Angle Unit



**mi - Milling Tool**

- 5 different CT plates
- chamfering
- milling threads
- milling planes
- counterboring
- Material: AlMgSi1 (DIN 3.2315)



**mi - Cutting Tool**

- jiggering
- chamfering
- Materials: 1. 20MnVS6 2. X15 CrNiSi20 (DIN 1.4828)



**mi - Cutting Tool**

- twist drill
- jiggering
- planing
- Material: Al-Si7Mg



**mi - Cutting Tool**

- drilling
- planing
- VHM twist drill
- chamfering



**mi - Milling Tool**

- groove milling
- Material: steel



**mi - Milling Tool**

- groove milling
- Material: steel



**mi - Milling Tool**

- contour milling
- Material: 16MnCrS5



**mi - Counterboring Tool**

- (jiggering)
- preturning
- finish-turning
- planing
- chamfering
- Material: Al-Si7Mg



**mi - Milling Tool**

- groove milling
- Material: steel








**mi - Milling Tool**

- groove milling
- Material: steel



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## 90° Adaptor for Turning Tools

for manufacturer

**SAUTER**

for turret type

**Star-type turret**

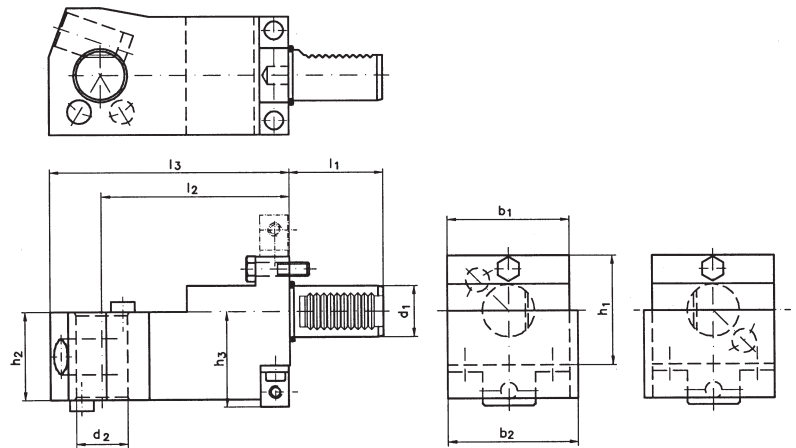


Illustration shows left version

left version

right version

For ordering please declare your required version (right-hand or left-hand)

Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	b1 mm	b2 mm	h1 mm	h2 mm	h3 mm
121243 (L) / 121218 (R)	VDI 20	20	20	40	75	100	54	59	54	44	42,0
121244 (L) / 121228 (R)	VDI 25	25	20	48	75	100	54	60	60	44	48,0
121201 (L) / 121266 (R)	VDI 25	25	25	48	75	100	54	63	60	44	48,0
121275 (L) / 121211 (R)	VDI 30	30	30	55	85	115	70	75	70	52	56,0
121239 (L) / 121214 (R)	VDI 30	30	30	55	100	130	70	75	70	52	56,0
121212 (L) / 121219 (R)	VDI 40	40	40	63	100	138	85	93	85	60	67,5
121223 (L) / 121229 (R)	VDI 40	40	40	63	120	158	85	93	85	60	67,5
121220 (L) / 121284 (R)	VDI 50	50	50	78	120	165	90	109	100	72	73,5

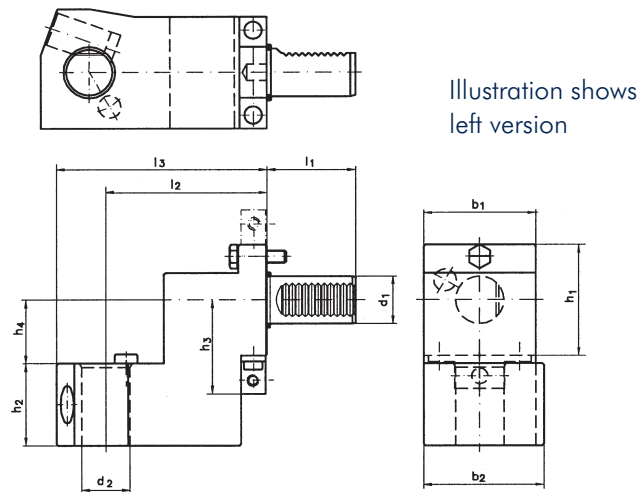
## 90° Adaptor for Turning Tools, Offset-Type

for manufacturer

**SAUTER**

for turret type

**Star-type turret**



For ordering please declare your required version (right-hand or left-hand)

Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	b1 mm	b2 mm	h1 mm	h2 mm	h3 mm	h4 mm
121215 (L) / 121254 (R)	VDI 20	20	20	40	75	100	54	59	54	44	42,0	30
121230 (L) / 121255 (R)	VDI 25	20	20	48	75	100	54	60	60	44	48,0	30
121293 (L) / 121256 (R)	VDI 25	25	25	48	75	100	54	63	60	44	48,0	30
121224 (L) / 121300 (R)	VDI 30	30	30	55	85	115	70	75	70	52	56,0	40
121231 (L) / 121232 (R)	VDI 30	30	30	55	100	130	70	75	70	52	56,0	40
121276 (L) / 121309 (R)	VDI 40	40	40	63	100	139	85	93	85	60	67,5	50
121301 (L) / 121225 (R)	VDI 40	40	40	63	120	159	85	93	85	60	67,5	50

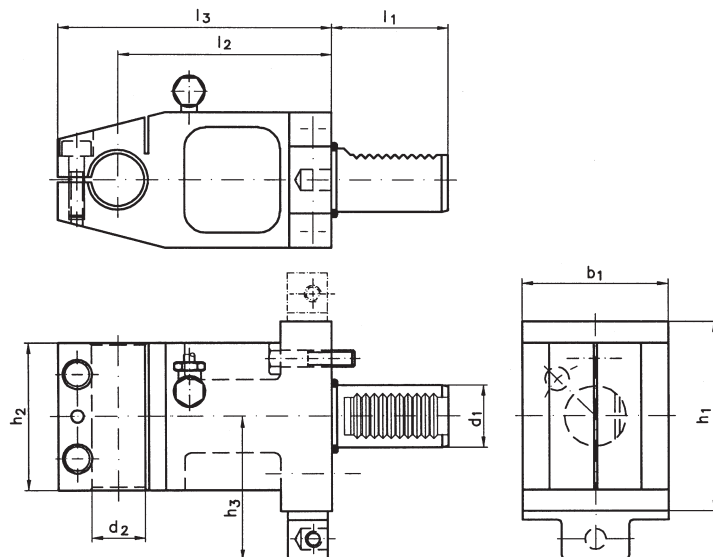
## Boring Bar Holder with Clamping

for manufacturer

**SAUTER**

for turret type

**Star-type turret**



Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	b1 mm	h1 mm	h2 mm	h3 mm
121302	VDI 20	20	25	40	75	99,5	54	54	48	42,0
121245	VDI 25	25	25	48	75	99,5	54	60	48	48,0
121294	VDI 30	30	25	55	85	113	64	70	70	56,0
121310	VDI 30	30	32	55	85	113	64	70	70	56,0
121216	VDI 30	30	25	55	100	128	64	70	70	56,0
121246	VDI 30	30	32	55	100	128	64	70	70	56,0
121318	VDI 40	40	32	63	100	132	76	85	85	67,5
121258	VDI 40	40	32	63	120	132	76	85	85	67,5

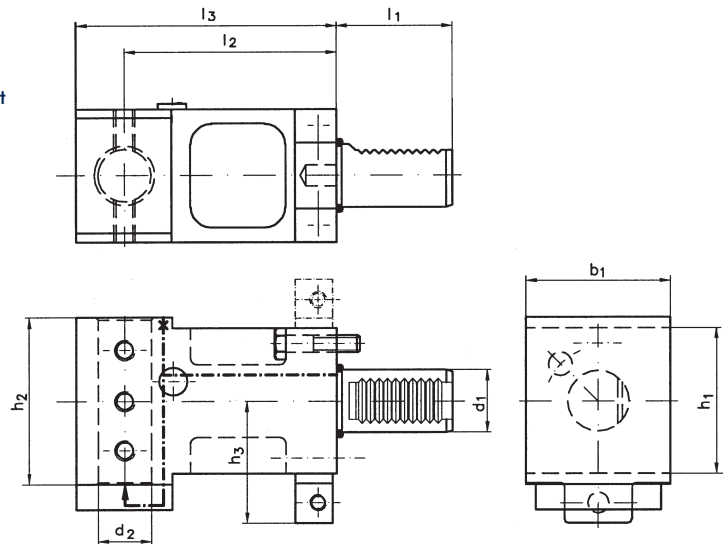
## Boring Bar Holder

for manufacturer  
**SAUTER**

for turret type  
**Star-type turret**



Internal coolant supply



Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	b1 mm	h1 mm	h2 mm	h3 mm
121267	VDI 20	20	25	40	75	97,5	54	54	60	42,0
121304	VDI 25	25	25	48	75	97,5	54	60	60	48,0
121327	VDI 30	30	32	55	85	108	64	70	70	56,0
121217	VDI 30	30	32	55	100	123	64	70	70	56,0
121247	VDI 40	40	40	63	100	132	76	85	85	67,5
121268	VDI 40	40	40	63	120	152	76	85	85	67,5
121328	VDI 50	50	50	78	120	160	85	100	100	73,5

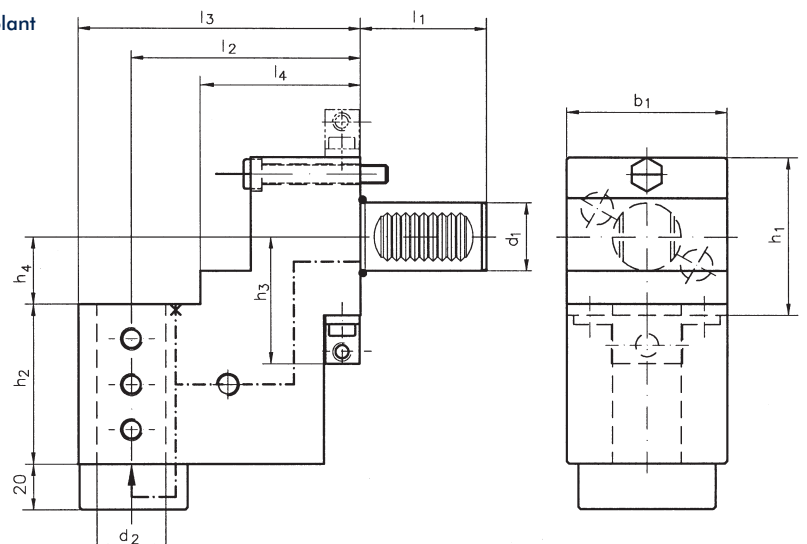
## Boring Bar Holder, Offset-Type

for manufacturer  
**SAUTER**

for turret type  
**Star-type turret**



Internal coolant supply



Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	l4 mm	b1 mm	h1 mm	h2 mm	h3 mm	h4 mm
121334	VDI 25	25	25	48	75	97,5	48	54	60	60	48,0	20
121279	VDI 30	30	32	55	100	123	70	64	70	70	56,0	30
121259	VDI 40	40	40	63	100	132	63	85	85	85	67,5	40

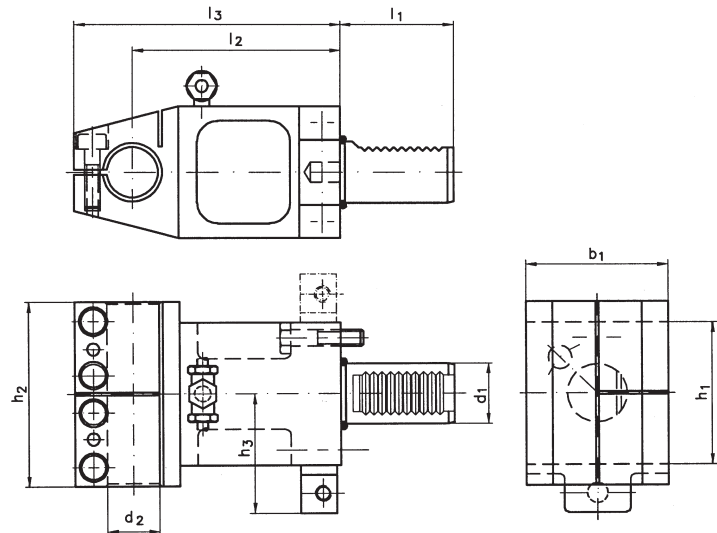
## Double Boring Bar Holder with Clamping

for manufacturer

**SAUTER**

for turret type

**Star-type turret**



Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	b1 mm	h1 mm	h2 mm	h3 mm
121277	VDI 20	20	25	40	75	99,5	54	54	75	42
121326	VDI 25	25	25	48	75	99,5	54	60	75	48
121278	VDI 30	30	32	55	85	113	64	70	94	56
121303	VDI 30	30	32	55	100	128	64	70	94	56

## Double Boring Bar Holder

for manufacturer

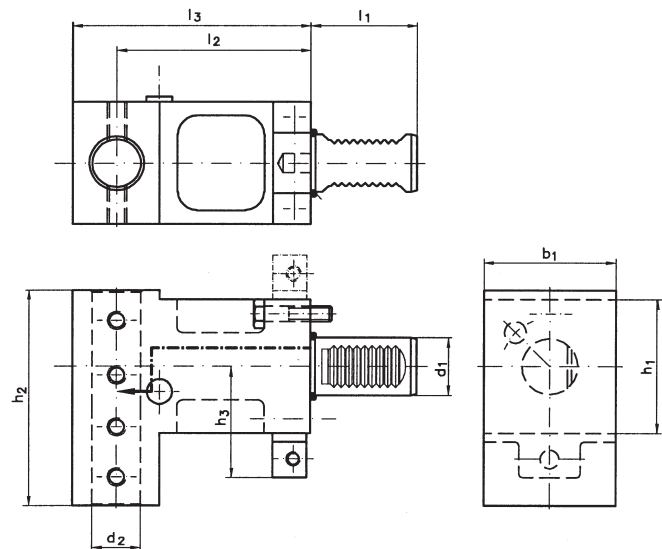
**SAUTER**

for turret type

**Star-type turret**



Internal coolant supply



For ordering please declare your required version (right-hand or left-hand)

Order No.	Size	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	b1 mm	h1 mm	h2 mm	h3 mm
121305 (L) / 121329 (R)	VDI 20	20	25	40	75	97,5	54	54	96	42,0
121260	VDI 20	20	25	40	75	97,5	54	54	96	42,0
121280 (L) / 121330 (R)	VDI 25	25	25	48	75	97,5	54	60	96	48,0
121281	VDI 25	25	25	48	75	97,5	54	60	96	48,0
121261 (L) / 121262 (R)	VDI 30	30	32	55	85	108	64	70	120	56,0
121312	VDI 30	30	32	55	85	108	64	70	120	56,0
121263 (L) / 121313 (R)	VDI 30	30	32	55	100	123	64	70	120	56,0
121269	VDI 30	30	32	55	100	123	64	70	120	56,0
121270	VDI 40	40	40	63	120	152	76	85	120	67,5

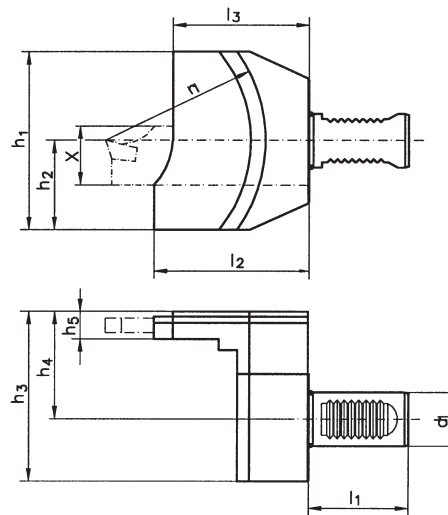
## Cutting Holder for „ISCAR“ Inserts

for manufacturer

**SAUTER**

for turret type

**Star-type turret**



Order No.	Size	d1 mm	l1 mm	l2 mm	l3 mm	h1 mm	h2 mm	h3 mm	h4 mm	h5 mm	r1 mm	X mm
121306	VDI 20	20	40	85,5	75	94	47	95	60	15,5	88	26
121285	VDI 25	25	48	85,0	75	73	39	72	43	15,5	88	26
121331	VDI 25	25	48	85,0	75	73	39	72	43	15,5	88	32
121332	VDI 30	30	55	85,5	75	100	50	95	60	15,5	88	26
121271	VDI 30	30	55	85,5	75	100	50	95	60	15,5	88	32
121282	VDI 40	40	63	85,5	75	100	50	95	60	15,5	88	26
121307	VDI 40	40	63	88,5	78	100	50	95	60	15,5	88	32

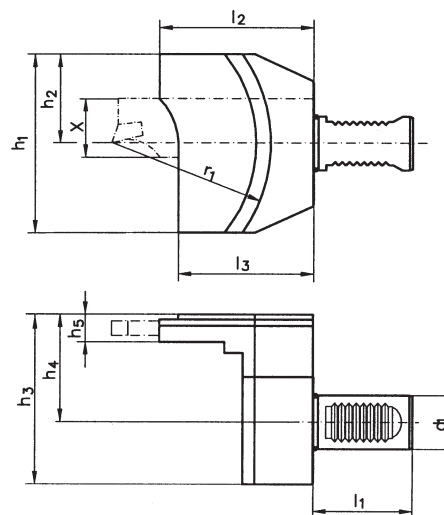
## Cutting Holder for „ISCAR“ Inserts, Overhead

for manufacturer

**SAUTER**

for turret type

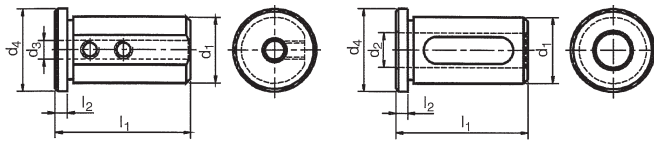
**Star-type turret**



Order No.	Size	d1 mm	l1 mm	l2 mm	l3 mm	h1 mm	h2 mm	h3 mm	h4 mm	h5 mm	r1 mm	X mm
121335	VDI 20	20	40	85,5	75	94	47	95	60	15,5	88	26
121339	VDI 25	25	48	85,0	75	73	39	72	43	15,5	88	26
121336	VDI 25	25	48	85,0	75	73	39	72	43	15,5	88	32
121264	VDI 30	30	55	85,5	75	100	50	95	60	15,5	88	26
121286	VDI 30	30	55	85,5	75	100	50	95	60	15,5	88	32
121314	VDI 40	40	63	85,5	75	100	50	95	60	15,5	88	26
121272	VDI 40	40	63	88,5	78	100	50	95	60	15,5	88	32

## Accessories for Sauter Boring Bar Holders

### Sleeve

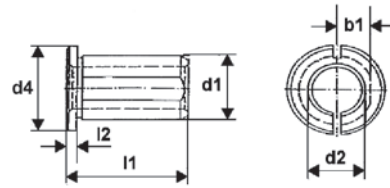


Pict. 1

Pict. 2

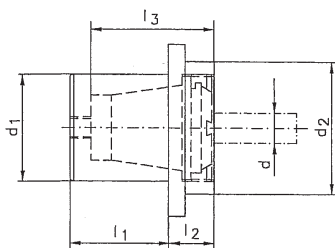
Order No.	Pict.	d1 mm	d2 mm	d3 mm	d4 mm	l1 mm	l2 mm
104527	1	25		6	29	50	4
104444	1	25		8	29	50	4
104445	1	25		10	29	50	4
104494	1	25		12	29	50	4
104537	2	25	16		29	50	4
104469	2	25	20		29	50	4
104528	1	32		6	36	58	5
104519	1	32		8	36	58	5
104454	1	32		10	36	58	5
104487	1	32		12	36	58	5
104548	2	32	16		36	58	5
104489	2	32	20		36	58	5
104522	2	32	25		36	58	5
104513	1	40		6	44	58	5
104507	1	40		8	44	58	5
104549	1	40		10	44	58	5
104531	1	40		12	44	58	5
104514	2	40	16		44	58	5
104555	2	40	20		44	58	5
104551	2	40	25		44	58	5
104609	2	40	32		44	58	5
104558	1	50		12	54	75	5
168951	1	50		6	54	75	5
104585	1	50		8	54	75	5
104552	1	50		10	54	75	5
104525	2	50	16		54	75	5
104586	2	50	20		54	75	5
104587	2	50	25		54	75	5
104588	2	50	32		54	75	5
104559	2	50	40		54	75	5

### Bushing, slottet



Order No.	d1 mm	d2 mm	d4 mm	l1 mm	l2 mm
104510	20	6	24	30	4
104492	20	8	24	30	4
104481	20	10	24	30	4
104461	20	12	24	30	4
104462	20	14	24	30	4
104501	20	15	24	30	4
104451	20	16	24	30	4
104418	25	6	29	40	4
104536	25	8	29	40	4
104493	25	10	29	40	4
104484	25	12	29	40	4
104504	25	14	29	40	4
104463	25	15	29	40	4
104545	25	16	29	40	4
104485	25	18	29	40	4
104511	25	20	29	40	4
104495	30	8	34	50	4
104496	30	10	34	50	4
104452	30	12	34	50	4
104470	30	15	34	50	4
104538	30	16	34	50	4
104539	30	20	34	50	4
104540	30	25	34	50	4
104453	32	8	36	50	4
104529	32	10	36	50	4
104486	32	12	36	50	4
104563	32	14	36	50	4
104497	32	15	36	50	4
104547	32	16	36	50	4
104488	32	18	36	50	4
104498	32	20	36	50	4
104543	32	25	36	50	4

### Collet Chuck for Boring Bar Holders



Order No.	d1 mm	d mm	d2 mm	l1 mm	l2 mm
121308	25	1-13	35	29	18
121315	32	1-16	40	32	20
121287	40	2-20	50	38	20

## VDI Toolholders

Our toolholders for CNC lathes feature cylindrical shanks acc. to DIN 69880/VDI 3425. They are made from case hardened steel, the hardness of the wearing surfaces is  $58 \pm 2$  HRC.

All functional surfaces are ground and browned. The tooling on the shank is ground.

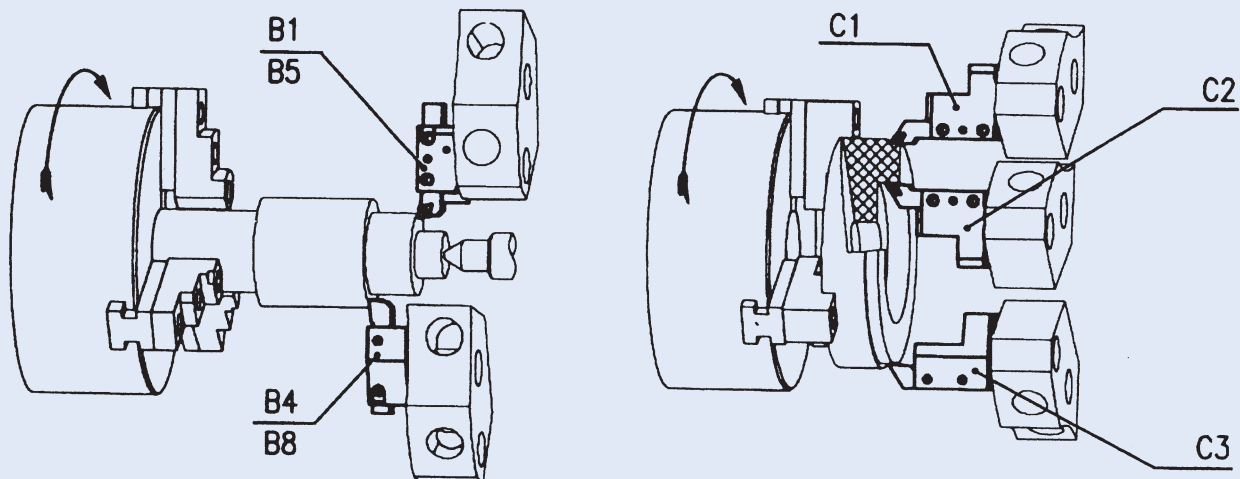
As far as technically possible, all tool holders are provided with internal coolant supply and adjustable ball-type nozzles.

They are fitted with a spring-loaded pressure plate.

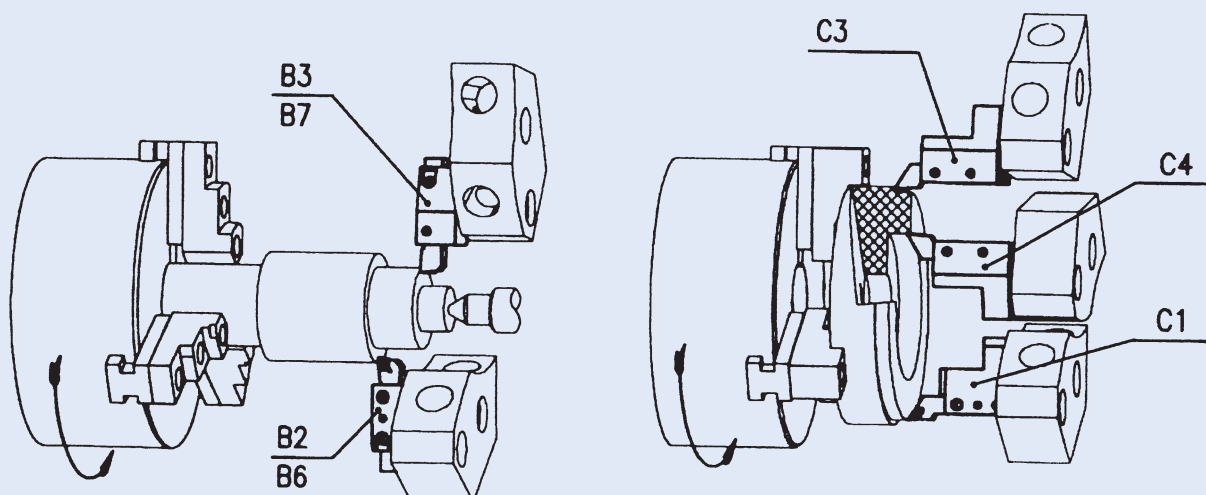
Further designs on request.



### Operation with Toolholders in Anti-clockwise Rotation



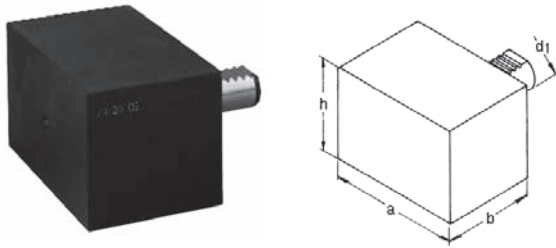
### Operation with Toolholders in Clockwise Rotation





## VDI Toolholders

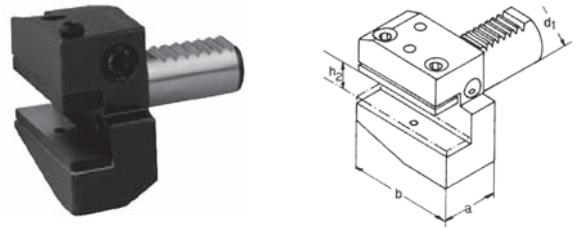
### Blanks



#### A1 rectangular

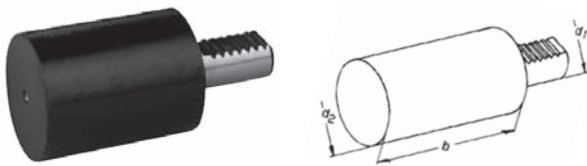
Order No.	d1 mm	a mm	h mm	b mm
105111	16	78	44	44
105163	20	100	60	65
105136	30	130	76	85
105154	40	151	96	100
105143	50	160	120	125
105171	60	165	125	160

### Radial Toolholders



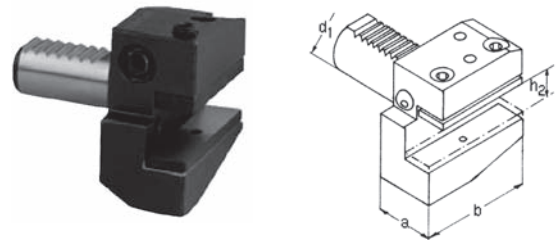
#### B1 right-hand, short

Order No.	d1 mm	h2 mm	a mm	b mm
104930	16	12/10	24	42
104900	20	16/12	30	55
104938	30	20/16	40	70
104939	40	25/20	44	85
104908	50	32/25	55	100
104909	60	32/25	60	125



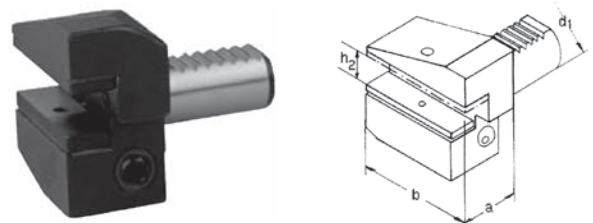
#### A2 round

Order No.	d1 mm	d2 mm	b mm
105161	16	40	60
105135	20	50	70
105092	30	68	100
105169	30	68	240
105137	40	83	120
105156	40	83	320
105157	50	98	135
105093	50	98	400
105170	60	123	150
105177	60	123	480



#### B2 left-hand, short

Order No.	d1 mm	h2 mm	a mm	b mm
104981	16	12/10	24	42
104958	20	16/12	30	55
104960	30	20/16	40	70
104988	40	25/20	44	85
104965	50	32/25	55	100
105025	60	32/25	60	125

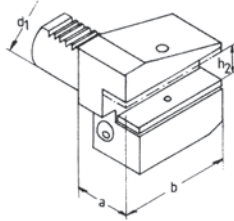


#### B3 overhead, right-hand, short

Order No.	d1 mm	h2 mm	a mm	b mm
104910	16	12/10	24	42
104904	20	16/12	30	55
104924	30	20/16	40	70
104949	40	25/20	44	85
104943	50	32/25	55	100
104970	60	32/25	60	125

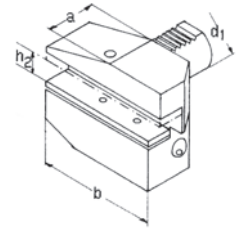
# VDI Toolholders

## Radial Toolholders



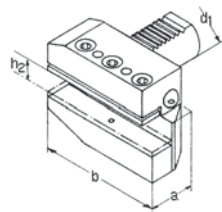
**B4 overhead, left-hand, short**

Order No.	d1 mm	h2 mm	a mm	b mm
104912	16	12/10	24	42
104927	20	16/12	30	55
104964	30	20/16	40	70
104956	40	25/20	44	85
104973	50	32/25	55	100
104935	60	32/25	60	125



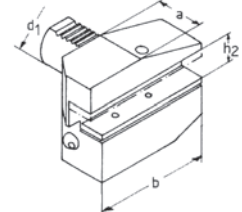
**B7 overhead, right-hand, long**

Order No.	d1 mm	h2 mm	a mm	b mm
104001	16	12/10	24	58
104025	20	16/12	30	75
104042	30	20/16	40	100
103985	40	25/20	44	118
104033	50	32/25	55	130
104008	60	32/25	60	145



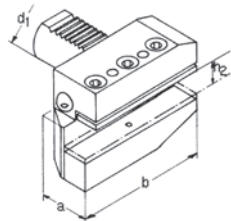
**B5 right-hand, long**

Order No.	d1 mm	h2 mm	a mm	b mm
104024	16	12/10	24	58
104032	20	16/12	30	75
103983	30	20/16	40	100
104007	40	25/20	44	118
103994	50	32/25	55	130
104050	60	32/25	60	145



**B8 overhead, left-hand, long**

Order No.	d1 mm	h2 mm	a mm	b mm
104060	16	12/10	24	58
103986	20	16/12	30	75
104061	30	20/16	40	100
104062	40	25/20	44	118
104034	50	32/25	55	130
104054	60	32/25	60	145

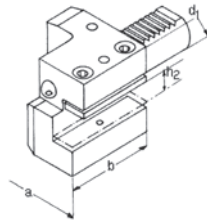


**B6 left-hand, long**

Order No.	d1 mm	h2 mm	a mm	b mm
104036	16	12/10	24	58
104003	20	16/12	30	75
104009	30	20/16	40	100
104043	40	25/20	44	118
104063	50	32/25	55	130
104077	60	32/25	60	145

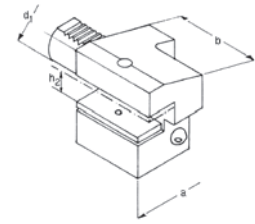
## VDI Toolholders

### Axial Toolholders



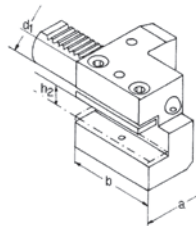
**C1 right-hand**

Order No.	d1 mm	h2 mm	b mm	a mm
103999	16	12/10	44	43
103928	20	16/12	50	52
103971	30	20/16	70	76
103992	40	25/20	85	85
103993	50	32/25	100	100
103982	60	32/25	125	125



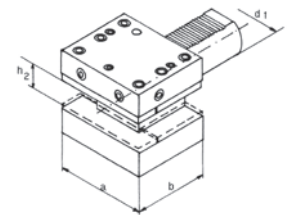
**C4 overhead, left-hand**

Order No.	d1 mm	h2 mm	b mm	a mm
104613	16	12/10	44	43
104569	20	16/12	50	52
104605	30	20/16	70	76
104606	40	25/20	85	85
104644	50	32/25	100	100
104570	60	32/25	125	125



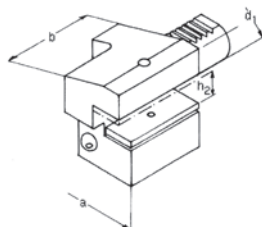
**C2 left-hand**

Order No.	d1 mm	h2 mm	b mm	a mm
104651	16	12/10	44	43
104715	20	16/12	50	52
104761	30	20/16	70	76
104661	40	25/20	85	85
104669	50	32/25	100	100
104753	60	32/25	125	125



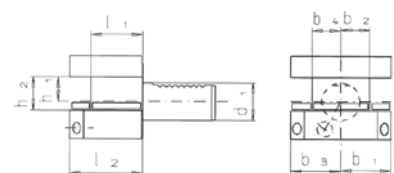
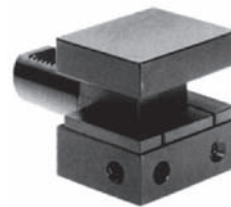
**D1 Axial multiple Toolholder**

Order No.	d1 mm	h2 mm	b mm	a mm
104064	30	20/16	60	76
104069	40	25/20	72	90
104056	50	32/25	85	105



**C3 overhead, right-hand**

Order No.	d1 mm	h2 mm	b mm	a mm
104184	16	12/10	44	43
104199	20	16/12	50	52
104209	30	20/16	70	76
104240	40	25/20	85	85
104201	50	32/25	100	100
104211	60	32/25	125	125

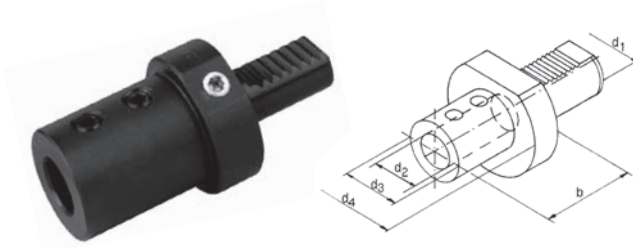


**D2 Axial multiple Toolholder, overhead**

Order No.	d1 mm	h2 mm	a mm	b mm
104086	30	20/16	60	76
104087	40	25/20	72	90
104013	50	32/25	85	105

## VDI Toolholders

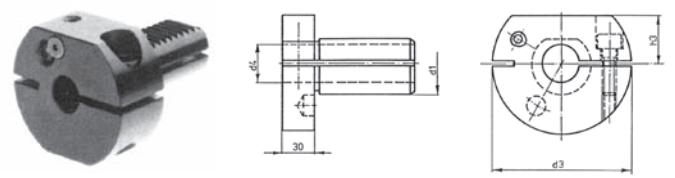
### U-Drill Holder



E1

Order No.	d1 mm	d2 mm	d4 mm	b mm
104403	20	10	50	
104399	20	12	50	
104381	20	16	50	66
104430	20	20	50	67
104382	20	25	50	71
104400	30	10	68	66
104362	30	12	68	66
104439	30	16	68	66
104414	30	20	68	67
104433	30	25	68	71
104434	30	32	68	75
104441	30	40	68	95
104391	40	10	83	66
104436	40	12	83	66
104456	40	16	83	66
104405	40	20	83	67
104465	40	25	83	75
104406	40	32	83	75
104474	40	40	83	90
104407	40	50	83	100
104408	50	10	98	67
104482	50	12	98	67
104476	50	16	98	67
104416	50	20	98	67
104459	50	25	98	80
104466	50	32	98	80
104483	50	40	98	90
104491	50	50	98	100
104467	60	10	123	80
104409	60	12	123	80
104417	60	16	123	80
104500	60	20	123	80
104477	60	25	123	80
104449	60	32	123	80
104509	60	40	123	90
104478	60	50	123	100

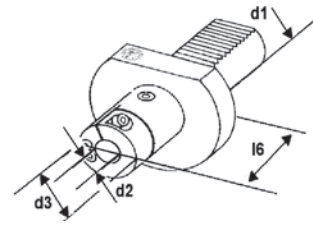
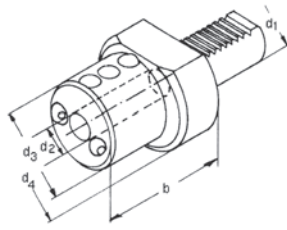
### Boring Bar Holder



Order No.	d1 mm	d4 mm	d3 mm	h3 mm
104202	30	12	68	28,0
104257	30	16	68	28,0
104224	30	20	68	28,0
104249	40	12	83	32,5
104225	40	16	83	32,5
104266	40	20	83	32,5
104226	40	25	83	32,5
104233	40	32	83	32,5
104250	50	12	98	35,0
104275	50	16	98	35,0
104267	50	20	98	35,0
104215	50	25	98	35,0
104234	50	32	98	35,0
104251	60	16	123	42,5
104242	60	20	123	42,5
104258	60	25	123	42,5
104170	60	32	123	42,5

## VDI Toolholders

### Boring Bar Holder



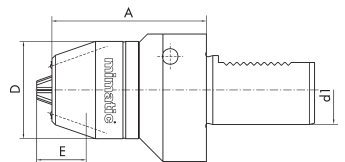
#### E2

Order No.	d1 mm	d2 mm	d4 mm	b mm
104139	16	6	40	44
104084	16	8	40	44
104085	16	10	40	44
104125	16	12	40	44
104149	16	16	40	44
104158	20	8	50	50
104126	20	10	50	50
104115	20	12	50	50
104159	20	16	50	50
104167	20	20	50	50
104150	20	25	50	60
104142	30	8	68	60
104195	30	10	68	60
104108	30	12	68	60
104130	30	16	68	60
104186	30	20	68	60
104178	30	25	68	60
104179	30	32	68	75
104153	40	8	83	75
104187	40	10	83	75
104109	40	12	83	75
104110	40	16	83	75
104155	40	20	83	75
104145	40	25	83	75
104119	40	32	83	75
104189	40	40	83	90
104168	50	12	98	90
104206	50	16	98	90
104182	50	20	98	90
104148	50	25	98	90
104207	50	32	98	90
104198	50	40	98	90
104157	50	50	98	100
104221	60	12	123	90
104192	60	16	123	90
104169	60	20	123	90
104164	60	25	123	90
104222	60	32	123	90
104165	60	40	123	90
104166	60	50	123	100

#### E2S slotted

Order No.	d1 mm	d2 mm	d3 mm	l6 mm
104194	30	6	30	57
104129	30	8	30	57
104107	30	10	36	57
104143	30	12	36	57
104203	30	16	40	57
104160	30	20	44	57
104204	30	25	49	72
104196	30	32	56	72
104144	40	10	36	62
104188	40	12	36	62
104111	40	16	40	62
104181	40	20	44	62
104118	40	25	49	77
104146	40	32	56	77
104163	40	40	64	77

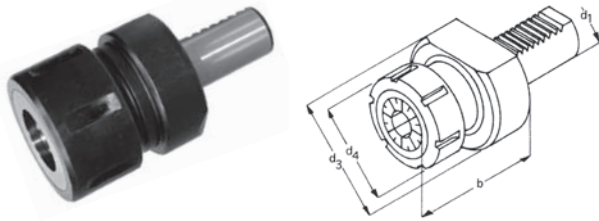
### Universal Chuck



Order No.	d1 mm	Range	A mm	D mm	E mm
131983	20	0,5-10	40	48,5	27
132019	30	0,5-13	90	56,5	29
132046	30	3,0-16	90	56,5	29
132006	40	0,5-13	90	56,5	29
132047	40	3,0-16	90	56,5	29
132033	50	0,5-13	90	56,5	29
132039	50	3,0-16	90	56,5	29

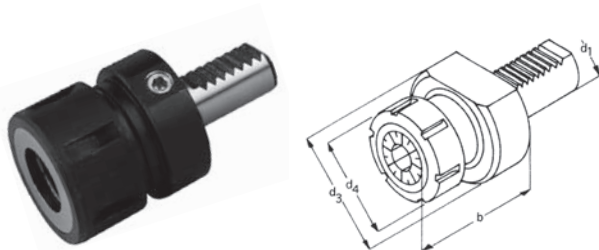
## VDI Toolholders

### Collet Chuck



#### OZ E3 DIN 6388

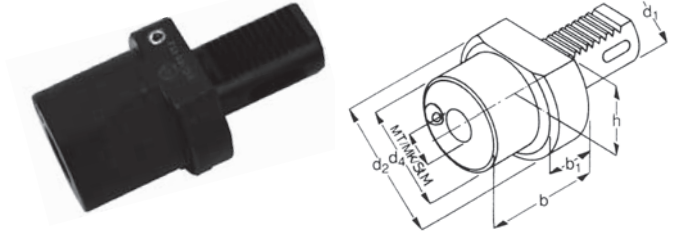
Order No.	d1 mm	Range	OZ	d3 mm	b mm
104653	16	1,5-16	415 E	40	65
104662	20	1,5-16	415 E	50	57
	20	2,0-20			62
104579	30	1,5-25	462 E	68	75
104655	40	1,5-25	462 E	83	75
104673	40	3,5-32	467 E	83	90
104631	50	1,5-25	462 E	98	75
104656	50	3,5-32	467 E	98	90
104642	60	3,5-32	467 E	123	90



#### ER E4 DIN 6499

Order No.	d1 mm	Range	ER	d3 mm	b mm
104614	16	0,5-10	ER 16	40	40
	16		ER 20		44
104576	20	0,5-10	ER 16	50	40
104628	20	0,5-16	ER 25	50	54
104571	30	0,5-16	ER 25	68	57
104629	30	1,0-20	ER 32	68	74
104645	30	2,0-30	ER 40	68	74
104646	40	0,5-16	ER 25	83	70
104615	40	1,0-20	ER 32	83	84
104594	40	2,0-30	ER 40	83	75
104616	50	2,0-30	ER 40	98	90
104619	60	2,0-30	ER 40	123	75

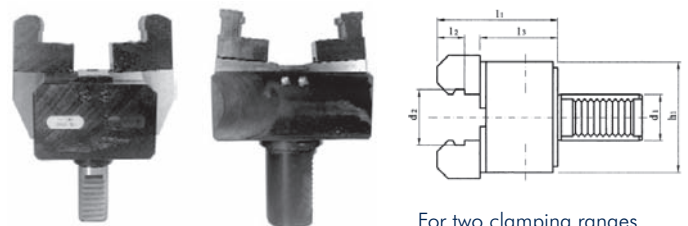
### Morse Taper Holder



#### F

Order No.	d1 mm	MK	h mm	d2 mm	b mm
104347	20	1	23,0	50	22
	20	2			90
104265	30	1	28,0	68	27
104297	30	2	28,0	68	36
104350	30	3	28,0	68	66
104352	40	2	32,5	83	36
104307	40	3	32,5	83	50
104299	40	4	32,5	83	80
104319	50	2	35,0	98	36
104383	50	3	35,0	98	45
104332	50	4	35,0	98	55
104328	50	5	35	98	68
104335	60	3	42,5	123	36
104393	60	4	42,5	123	50
104394	60	5	42,5	123	81

### Bar Puller



For two clamping ranges with reverse jaws

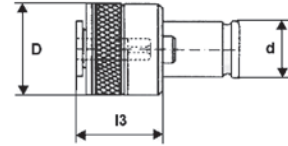
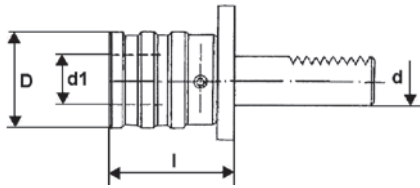
#### KH

Order No.	d1 mm	Range #1	Range #2	b1 mm	h1 mm	l1 mm	l2 mm	l3 mm
104733	16	6-56						
104757	20	6-45	45-100	50	72	46	4	51
104806	30	6-56	54-100	50	72	46	4	51
104798	40*	6-60	54-110	60	110	48	4	53
104789	50	6-75	62-110	65	130	67	5	73

\* With reversible clamping jaws

## VDI Toolholders

### Quick Change Tapping Chucks



#### With length compensation on traction and pressure

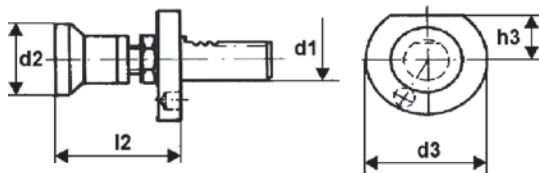
Order No.	d mm	Size	D mm	d1 mm	l mm
104815	20	SES 1	36	19	52,2
104800	30	SES 1	38	19	55,0
104739	30	SES 2	54	31	77,0
104758	40	SES 1	38	19	55,0
104780	40	SES 2	54	31	77,0
104807	40	SES 3	78	48	122,0
104759	50	SES 1	36	19	52,2
104781	50	SES 2	53	31	76,0
104740	50	SES 3	78	48	108,0
104801	50	SES 4	96	60	122,0
104802	60	SES 4	96	60	119,0

#### Quick change insert with safety coupling

Order No.	Range	Size	d mm	D mm	l3 mm
104819	M10	SES 1	19	32,6	25
12.4605Mxx	M8 -M20	SES 2	31	50,5	31
12.4606Mxx	M14-M33	SES 3	48	72,0	45
12.4608Mxx	M22-M48	SES 4	60	95,0	68

Please specify the thread or the dimension of the tap. Represents new order numbers from 104767 to 104860.

### Material Stop



#### MW travelling, adjustable

Order No.	d1 mm	d2 mm	d3 mm	l2 mm	h3 mm
104308	20	26	50	50-70	23,0
104341	20	32	50	50-70	23,0
104377	20	42	50	50-70	23,0
104326	30	32	68	62-95	28,0
104309	30	42	68	62-95	28,0
104358	30	58	68	62-95	28,0
104334	40	32	83	62-95	32,5
104283	40	42	83	62-95	32,5
104301	40	58	83	62-95	32,5

### Protection Plug



#### Z2 Steel/Plastic

Order No.	d1 mm	Material	D mm	l mm
104611	16	steel	40	13
104561	16	plastic	40	13
104567	20	steel	50	16
104601	20	plastic	50	16
104602	30	steel	68	16
104532	30	plastic	68	16
104603	40	steel	83	20
104612	40	plastic	83	20
104562	50	steel	98	20
104575	50	plastic	98	20
104604	60	steel	123	20
104635	60	plastic	123	20



## Accessories

### Wrenches and Clamping Nuts



#### Wrench for ER Clamping Nuts

Order No.	Size	Type
112912	ER 11	inlying
112954	ER 16	inlying
112929	ER 20	inlying
112913	ER 25	inlying
112900	ER 32	inlying
112867	ER 40	inlying
107628	ER 40	outlying

#### ER Clamping Nuts

Order No.	Size	Type	Internal coolant
112953	ER 11	inlying	
112860	ER 16	inlying	
112938	ER 20	inlying	
112961	ER 25	inlying	
112977	ER 32	inlying	
112946	ER 40	inlying	
112962	ER 16	inlying	✓
112940	ER 20	inlying	✓
112901	ER 25	inlying	✓
112963	ER 32	inlying	✓
112978	ER 40	inlying	✓
112513	ER 40	outlying	
117744	ER 40	outlying	✓

### Hook wrench to hold against

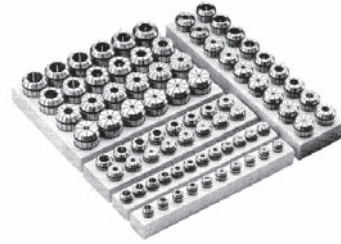
#### DIN 1810 A



#### DIN 1810 B



### Collet Sets



#### DIN 6499-B, Class 2

Order No.	Pieces	Size	Range
152712	10	ER 16	1-10
120174	12	ER 20	2-13
152713	15	ER 25	2-16
152715	18	ER 32	3-20
152716	23	ER 40	4-26

#### DIN 6499-B, (6 µm)

Order No.	Pieces	Size	Range
120131	10	ER 16	1-10
120154	12	ER 20	2-13
120349	15	ER 25	2-16
120612	18	ER 32	3-20
120730	23	ER 40	4-26

#### Threading Collets Type ET with length compensation

Order No.	ET	Pieces	Size	Range
152717	16	9	2,5-6	M1-M8
152718	25	8	2,8-9	M2-M12
120847	32	8	4,5-12	M4-M16
120827	40	9	6,0-16	M4-M22

Order No.	Size	Type	DIN
107557	ER 16	inlying	1810-B
107608	ER 20	inlying	1810-B
107446	ER 25	inlying	1810-B
107558	ER 25	outlying	1810-A
107642	ER 32	inlying	1810-B
107607	ER 32	outlying	1810-B
107566	ER 40	inlying	1810-B
107446	ER 40	outlying	1810-A
107605		Sawblade holder	1810-A
107447		Milling arbor 22	1810-B



## Accessories

### ER Seal Disc

Order No.	Size	Tightness range (mm)
172713	ER 16	3,0-2,5
173372		4,0-3,5
163515		5,0-4,5
112891		6,0-5,5
163516		7,0-6,5
112897		8,0-7,5
163517		9,0-8,5
172458		10,0-9,5
163519		3,0-2,5
163518		4,0-3,5
163520	5,0-4,5	
112744	6,0-5,5	
112855	7,0-6,5	
112865	8,0-7,5	
163521	9,0-8,5	
112844	10,0-9,5	
163522	11,0-10,5	
112892	12,0-11,5	
112863	ER 20	3,0-2,5
112833		4,0-3,5
112753		5,0-4,5
112871		6,0-5,5
112839		7,0-6,5
112817		8,0-7,5
112890		9,0-8,5
112811		10,0-9,5
112752		11,0-10,5
112861		12,0-11,5
112870	13,0-12,5	
112798	14,0-13,5	
112862	15,0-14,5	
112837	16,0-15,5	
112704	ER 25	3,0-2,5
112705		4,0-3,5
112726		5,0-4,5
112831		6,0-5,5
112832		7,0-6,5
112834		8,0-7,5
112835		9,0-8,5
112725		10,0-9,5
112779		11,0-10,5
112733		12,0-11,5
112804	13,0-12,5	
112827	14,0-13,5	
112688	15,0-14,5	
112806	16,0-15,5	
112809	17,0-16,5	
112769	18,0-17,5	
112797	19,0-18,5	
112829	20,0-19,5	
	ER 32	

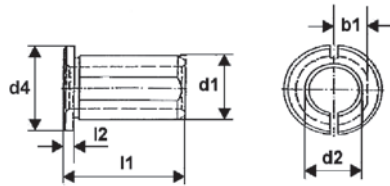
Order No.	Size	Tightness range (mm)
112910	ER 40	3,0-2,5
112951		4,0-3,5
112884		5,0-4,5
112959		6,0-5,5
112846		7,0-6,5
112911		8,0-7,5
112952		9,0-8,5
112821		10,0-9,5
112916		11,0-10,5
112924		12,0-11,5
112894	13,0-12,5	
112881	14,0-13,5	
112942	15,0-14,5	
112822	16,0-15,5	
112770	17,0-16,5	
112762	18,0-17,5	
112882	19,0-18,5	
112845	20,0-19,5	
112823	21,0-20,5	
112934	22,0-21,5	
112944	23,0-22,5	
112858	24,0-23,5	
112771	25,0-24,5	
112824	26,0-25,5	

### Set of Seal Disc

Order No.	Size	Piece	Tightness range (mm)	Grading
167490	ER 16	14	3,0-10	0,5
112907	ER 20	20	3,0-13	0,5
112735	ER 25	26	3,0-16	0,5
112715	ER 32	34	3,0-20	0,5
166918	ER 40	46	3,5-26	0,5

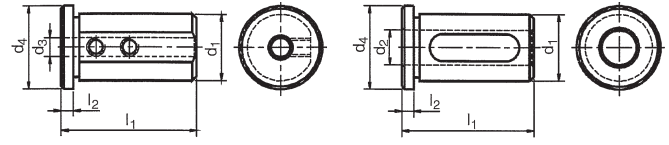
# Accessories for Toolholder VDI 3425

## Reducing Sleeve, Slotted



Order No.	d1 mm	d2 mm	d4 mm	l1 mm	l2 mm
104510	20	6	24	30	4
104492	20	8	24	30	4
104481	20	10	24	30	4
104461	20	12	24	30	4
104462	20	14	24	30	4
104501	20	15	24	30	4
104451	20	16	24	30	4
104418	25	6	29	40	4
104536	25	8	29	40	4
104493	25	10	29	40	4
104484	25	12	29	40	4
104504	25	14	29	40	4
104463	25	15	29	40	4
104545	25	16	29	40	4
104485	25	18	29	40	4
104511	25	20	29	40	4
104453	32	8	36	50	4
104529	32	10	36	50	4
104486	32	12	36	50	4
104563	32	14	36	50	4
104497	32	15	36	50	4
104547	32	16	36	50	4
104488	32	18	36	50	4
104498	32	20	36	50	4
104543	32	25	36	50	4
104508	40	10	44	78	4
104565	40	12	44	78	4
104550	40	14	44	78	4
104523	40	15	44	78	4
104582	40	16	44	78	4
104524	40	18	44	78	4
104591	40	20	44	78	4
104584	40	25	44	78	4
104608	40	32	44	78	4

## Reducing Sleeve



Pict. 1

Pict. 2

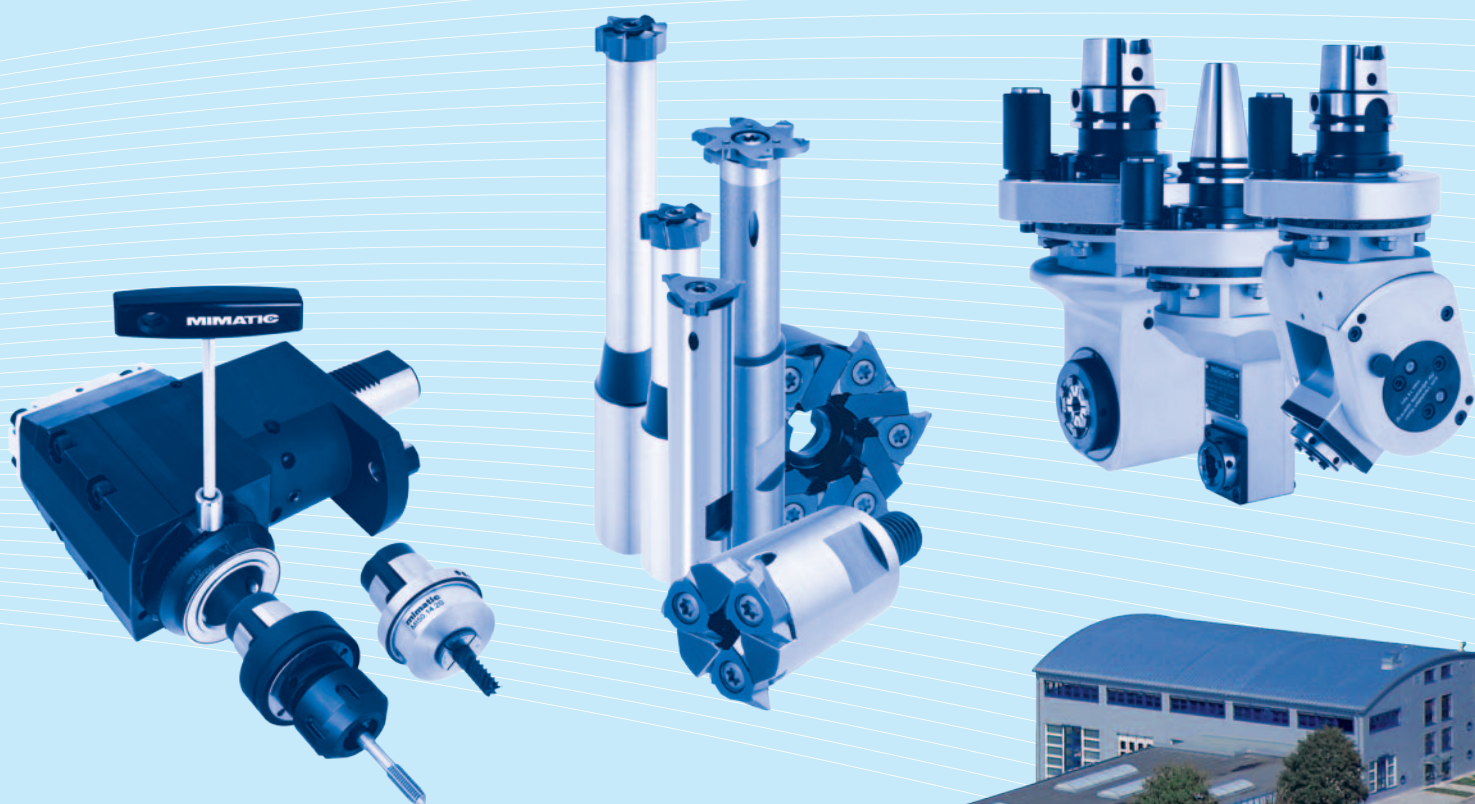
Order No.	Pict.	d1 mm	d2 mm	d3 mm	d4 mm	l1 mm	l2 mm
104527	1	25		6	29	50	4
104444	1	25		8	29	50	4
104445	1	25		10	29	50	4
104494	1	25		12	29	50	4
104537	2	25	16		29	50	4
104469	2	25	20		29	50	4
104528	1	32		6	36	58	5
104519	1	32		8	36	58	5
104454	1	32		10	36	58	5
104487	1	32		12	36	58	5
104548	2	32	16		36	58	5
104489	2	32	20		36	58	5
104522	2	32	25		36	58	5
104513	1	40		6	44	58	5
104507	1	40		8	44	58	5
104549	1	40		10	44	58	5
104531	1	40		12	44	58	5
104514	2	40	16		44	58	5
104555	2	40	20		44	58	5
104551	2	40	25		44	58	5
104609	2	40	32		44	58	5
168951	1	50		6	54	75	5
104585	1	50		8	54	75	5
104552	1	50		10	54	75	5
104558	1	50		12	54	75	5
104525	2	50	16		54	75	5
104586	2	50	20		54	75	5
104587	2	50	25		54	75	5
104588	2	50	32		54	75	5
104559	2	50	40		54	75	5





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- Static Toolholders for CNC Turning Machines
- Precision Chucks
- Special Cutting Tools

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